US009122202B2

(12) **United States Patent**
Hori et al.

(10) **Patent No.: US 9,122,202 B2**
(45) **Date of Patent: Sep. 1, 2015**

(54) **TONER CONTAINER, IMAGE FORMING APPARATUS INCLUDING SAME, AND CONNECTING STRUCTURE FOR CONNECTING TONER CONTAINER AND IMAGE FORMING APPARATUS**

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(72) Inventors: **Eisuke Hori**, Ota-ku (JP); **Yuji Suzuki**, Ota-ku (JP); **Hideki Kimura**, Yokohama (JP); **Kenji Kikuchi**, Yokohama (JP); **Noriyuki Kimura**, Kawasaki (JP); **Nobuo Takami**, Kawasaki (JP)

(73) Assignee: **RICOH COMPANY, LIMITED**, Tokyo (JP)

(*) Notice: Subject to any disclaimer, the term of this patent is extended or adjusted under 35 U.S.C. 154(b) by 0 days.

(21) Appl. No.: **14/148,328**

(22) Filed: **Jan. 6, 2014**

(65) **Prior Publication Data**

US 2014/0119780 A1 May 1, 2014

Related U.S. Application Data

(63) Continuation of application No. 12/875,762, filed on Sep. 3, 2010, now Pat. No. 8,649,713.

(30) **Foreign Application Priority Data**

Sep. 4, 2009	(JP)	2009-204358
Jun. 11, 2010	(JP)	2010-134544
Jun. 30, 2010	(JP)	2010-148907

(51) **Int. Cl.**
G03G 15/08 (2006.01)

(52) **U.S. Cl.**
CPC ***G03G 15/0867*** (2013.01); ***G03G 15/0868*** (2013.01); ***G03G 15/0879*** (2013.01); ***G03G 15/0886*** (2013.01); *G03G 2215/0668* (2013.01); *G03G 2215/0678* (2013.01)

(58) **Field of Classification Search**
CPC G03G 15/0867; G03G 15/0868; G03G 15/0879; G03G 15/0886; G03G 2215/0668; G03G 2215/0678
USPC 399/119, 120, 262
See application file for complete search history.

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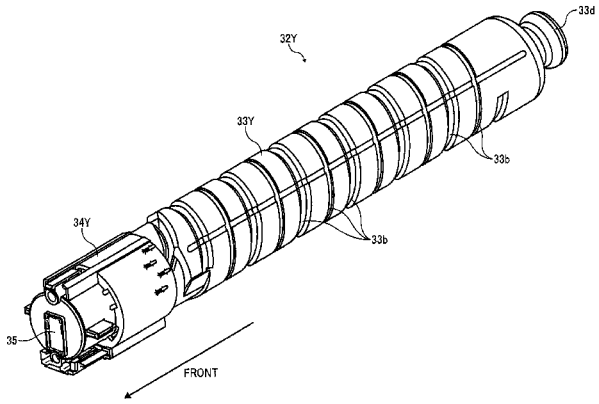
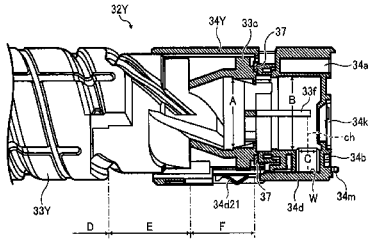
Primary Examiner — Ryan Walsh
(74) *Attorney, Agent, or Firm* — Oblon, McClelland, Maier & Neustadt, L.L.P.

(57) **ABSTRACT**

A toner container includes a cylindrical container body, a cap having a toner outlet, and a shutter. The cap includes a primary positioning primary positioning hole, formed in a top front surface perpendicular to a longitudinal direction of the toner container, extending in the longitudinal direction, to determine an installation position of the cap relative to the image forming apparatus, a secondary positioning hole, formed in a bottom front surface perpendicular to the longitudinal direction of the toner container, extending in the longitudinal direction forward the toner outlet, to subsidiary determine the installation position of the cap, and a first restriction member to position the cap in a horizontal direction perpendicular to the longitudinal direction, projecting vertically upward from an outer circumferential surface of the cap and symmetrical about a virtual perpendicular line passing through a cross-sectional center position of the primary positioning hole perpendicular to the longitudinal direction.

13 Claims, 44 Drawing Sheets





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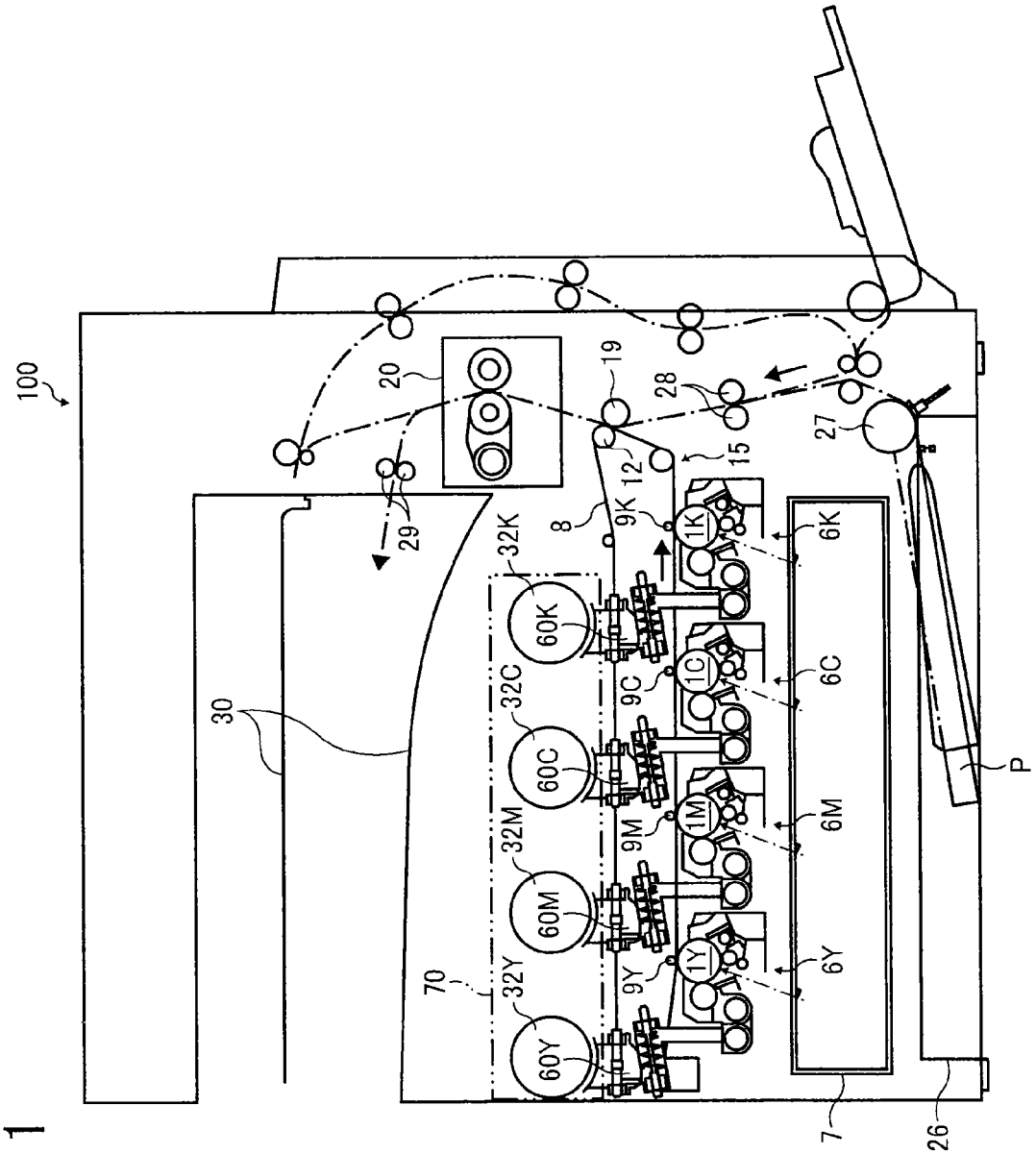
JP	4456957		2/2010

* cited by examiner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20
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27
15
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9K
8
29
32K
60K
1K
6K
30
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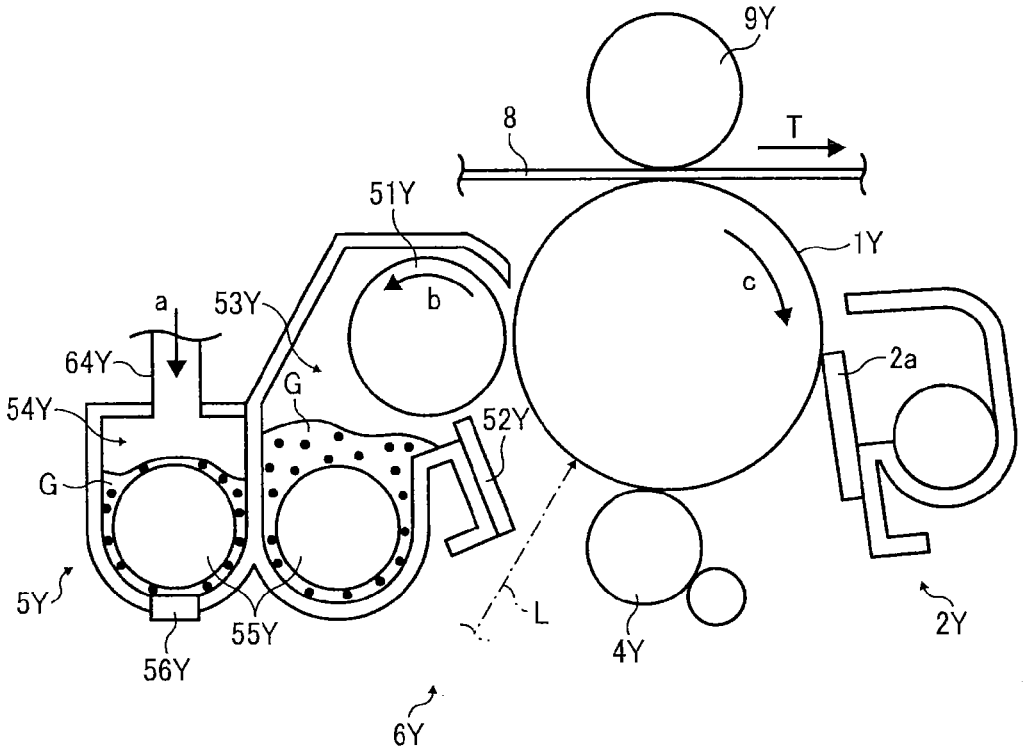
60C
9C
1C
6C
P
32M
60M
9M
1M
6M
70
32Y
60Y
9Y
1Y
6Y
7
26

FIG. 1

FIG. 2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8
T
51Y
1Y
a
53Y
b
c
64Y
G
2a
54Y
52Y
G
5Y
55Y
L
2Y
56Y
4Y
6Y

FIG. 3

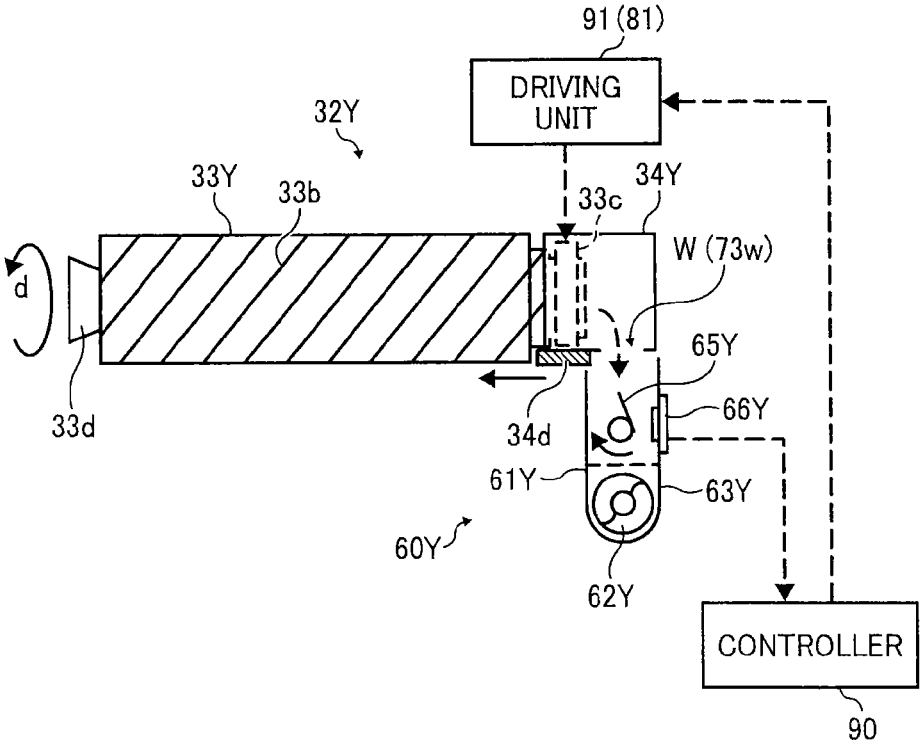

91 (81)
DRIVING UNIT
32Y
33Y
33b
33c
34Y
W (73w)
d
65Y
66Y
33d
34d
61Y
63Y
60Y
62Y
CONTROLLER
90

FIG. 4

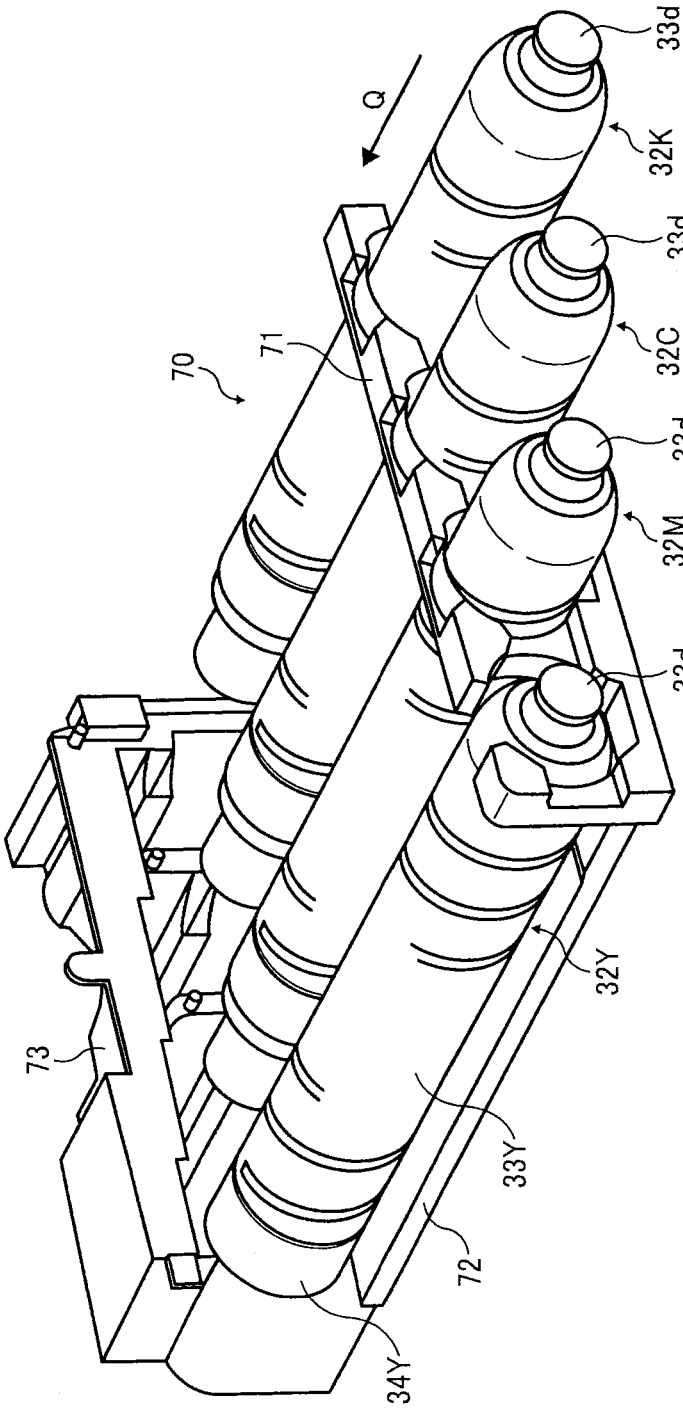


FIG. 5

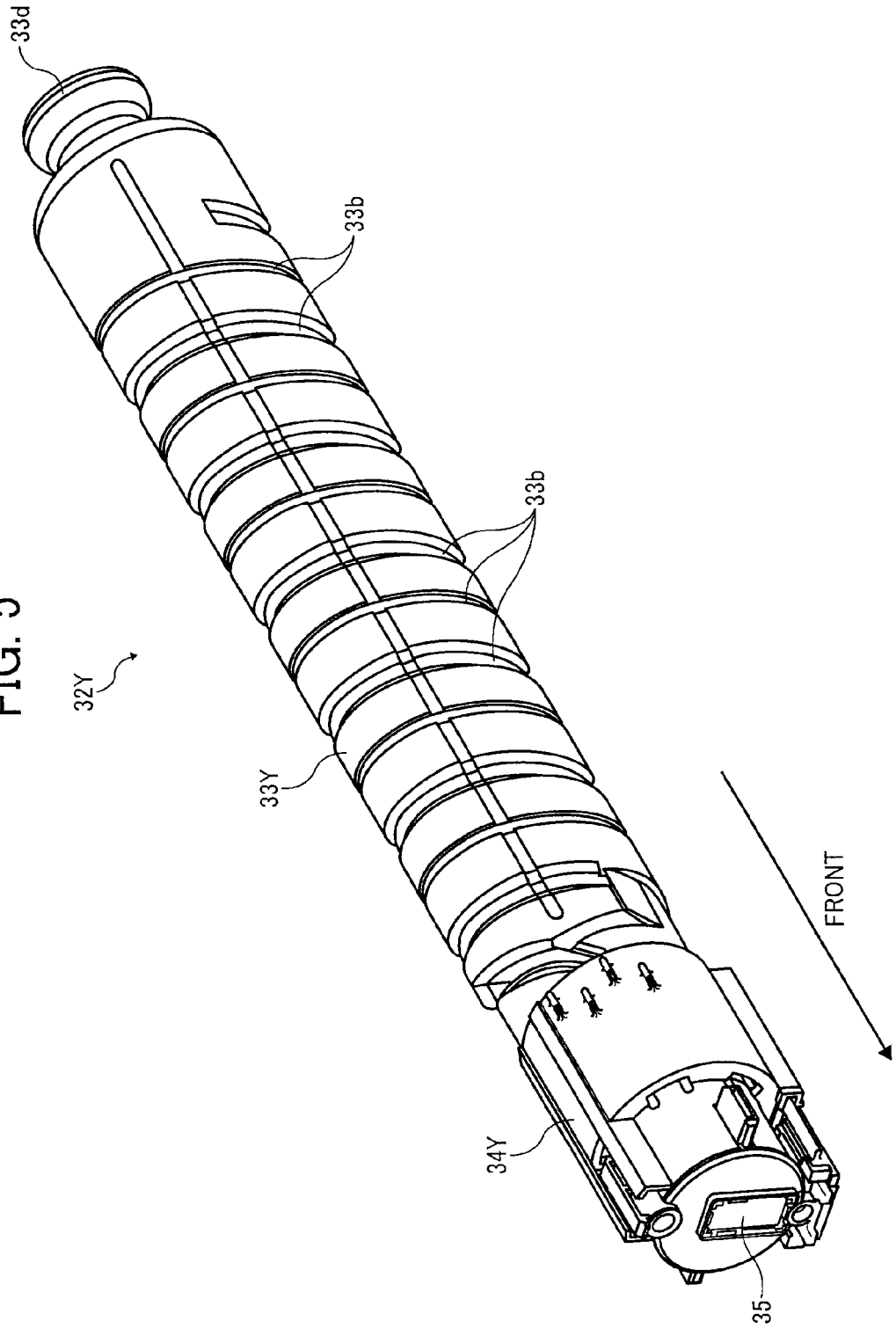


FIG. 6

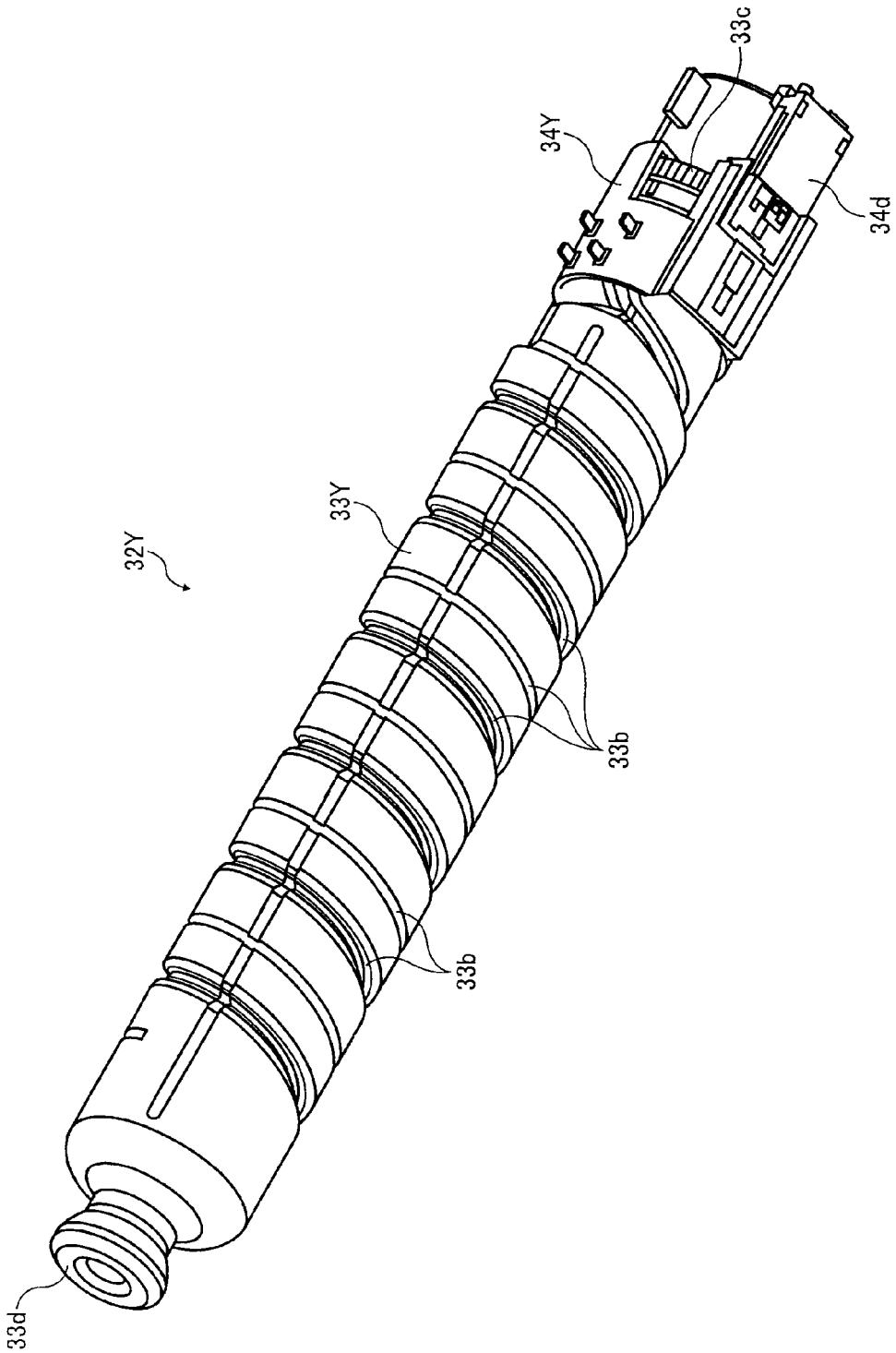
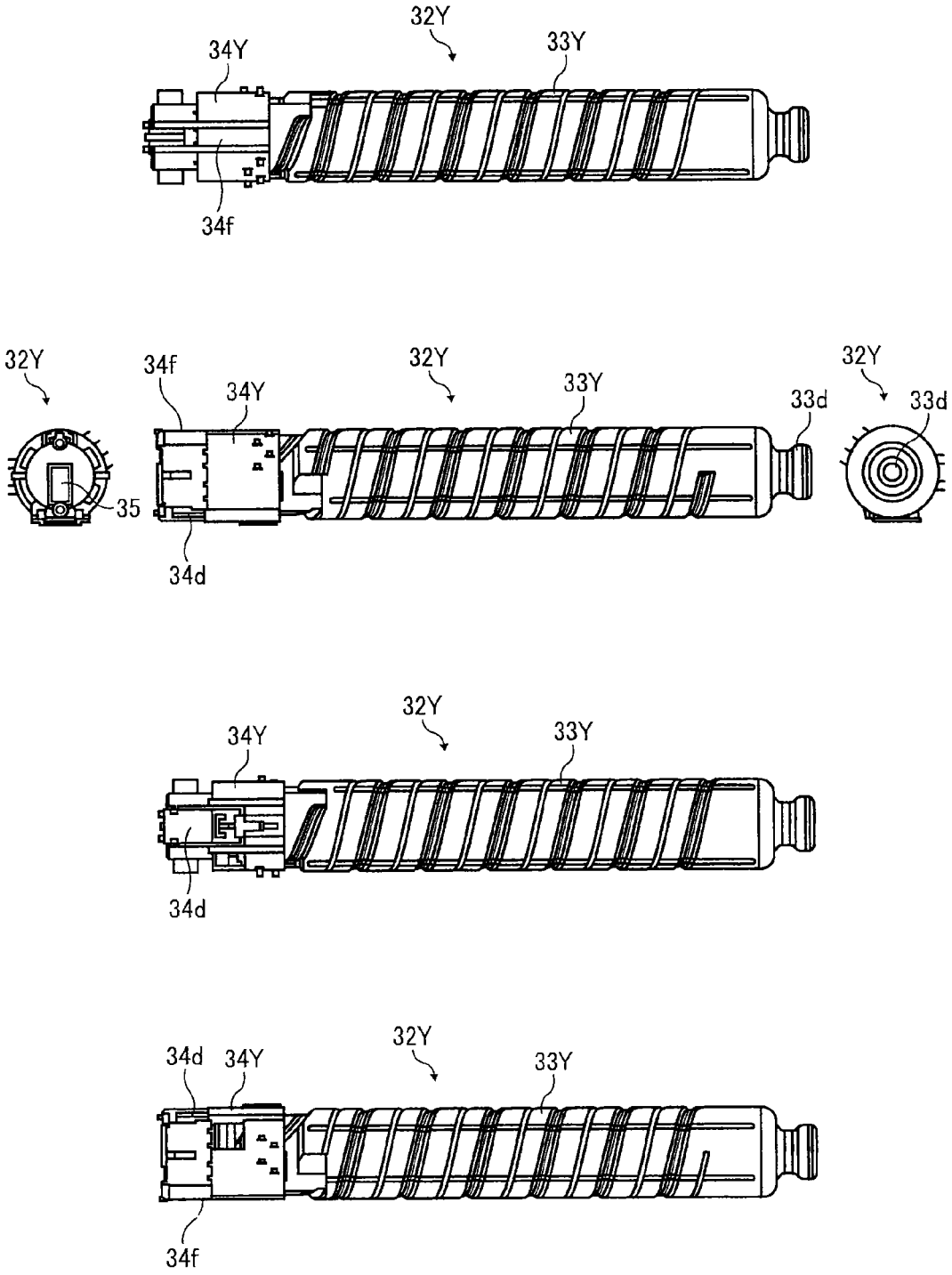


FIG. 7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33Y
34f
32Y
34f
34Y
32Y
33Y
33d
32Y
33d
35
34d
32Y
34Y
33Y
34d
34d
34Y
32Y
33Y
34f

FIG. 8

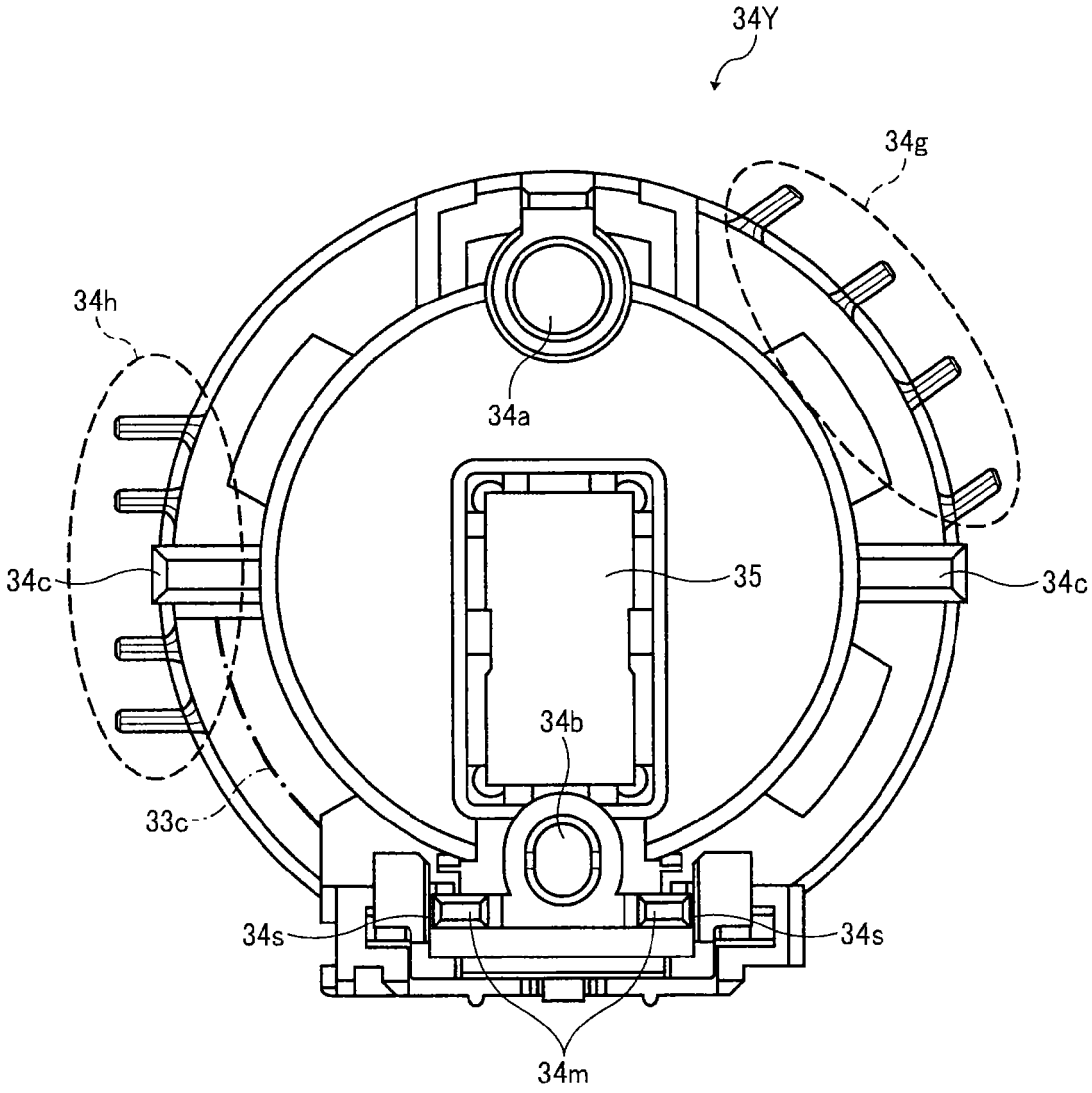


FIG. 9A

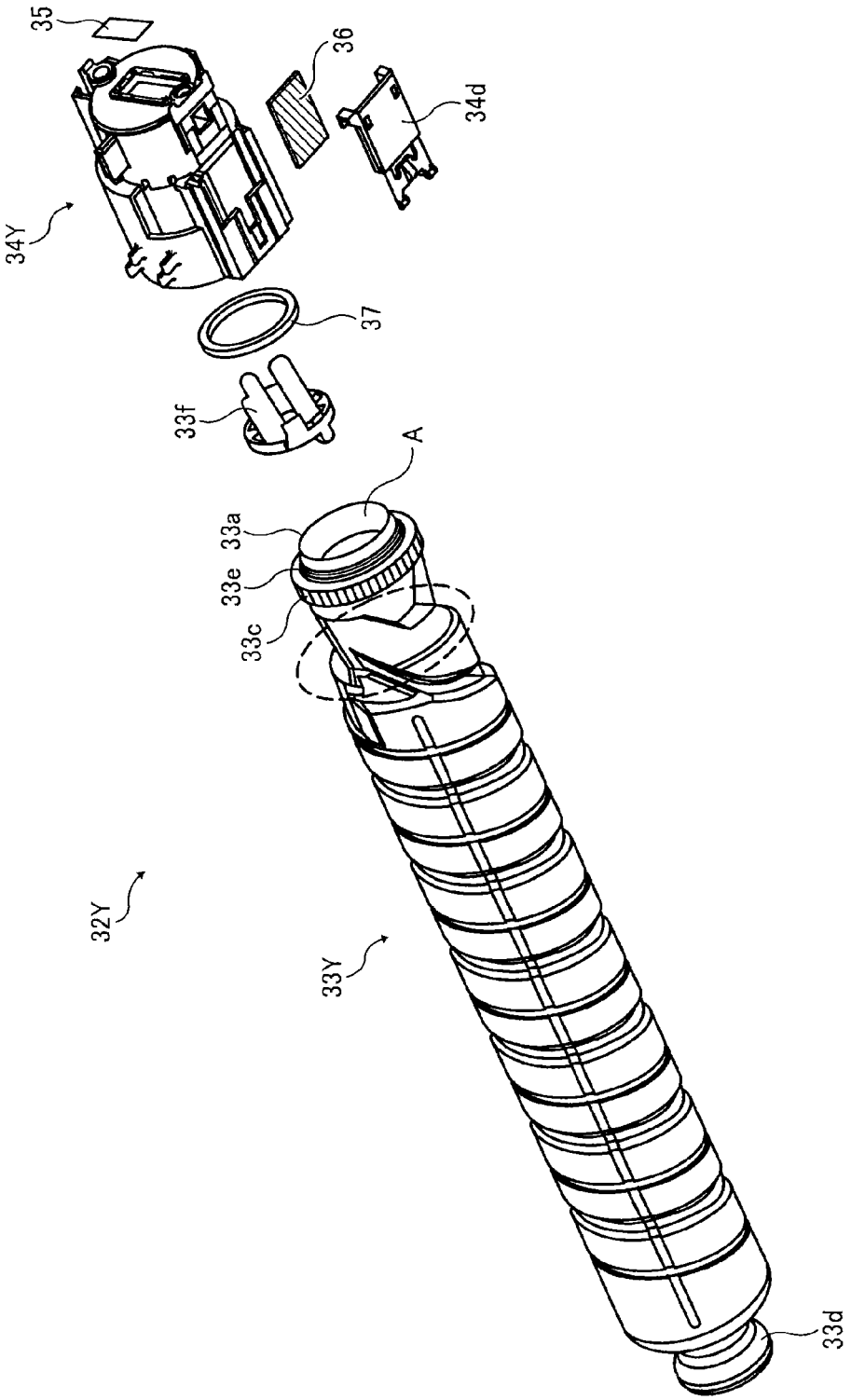


FIG. 9B

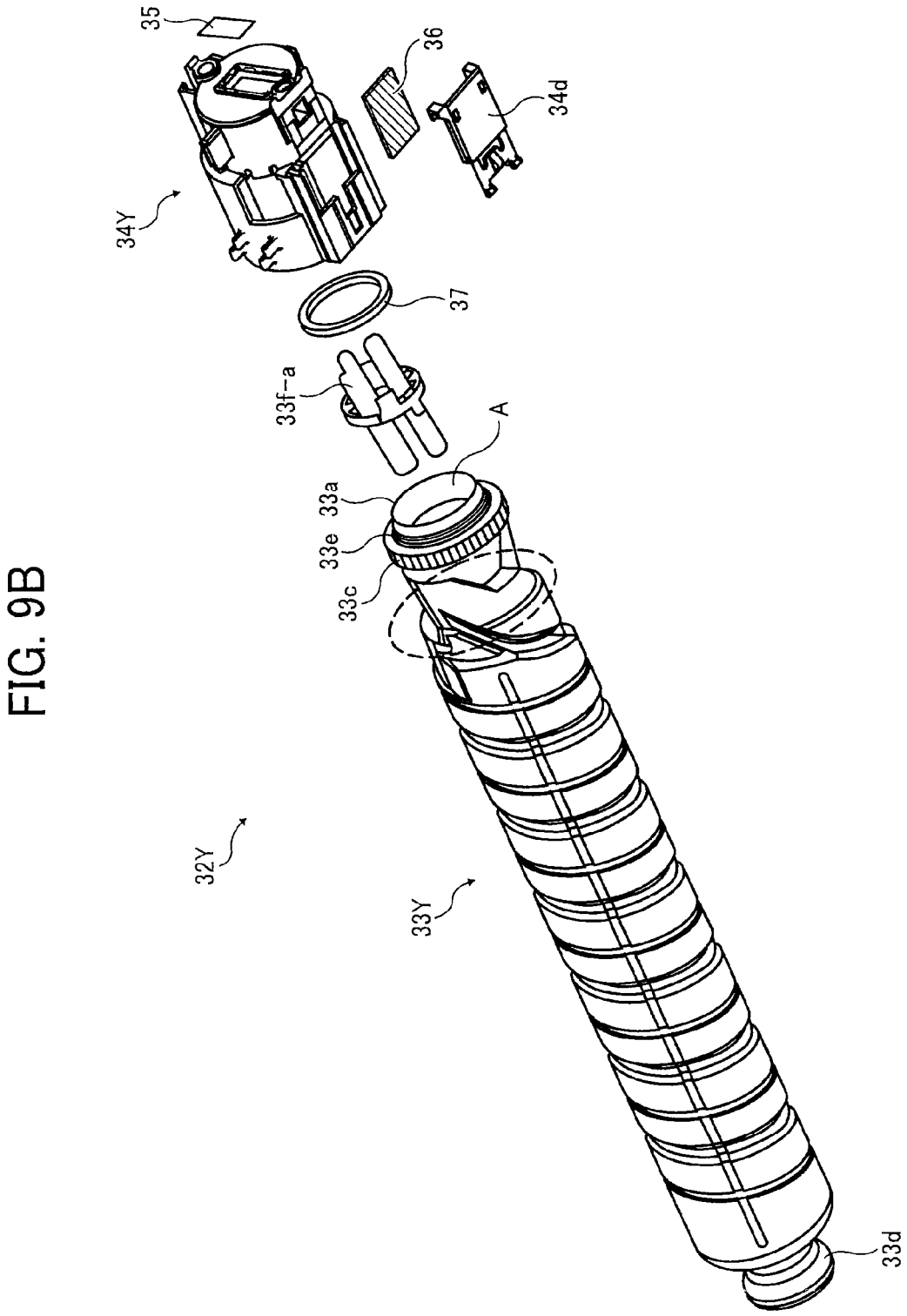


FIG. 10

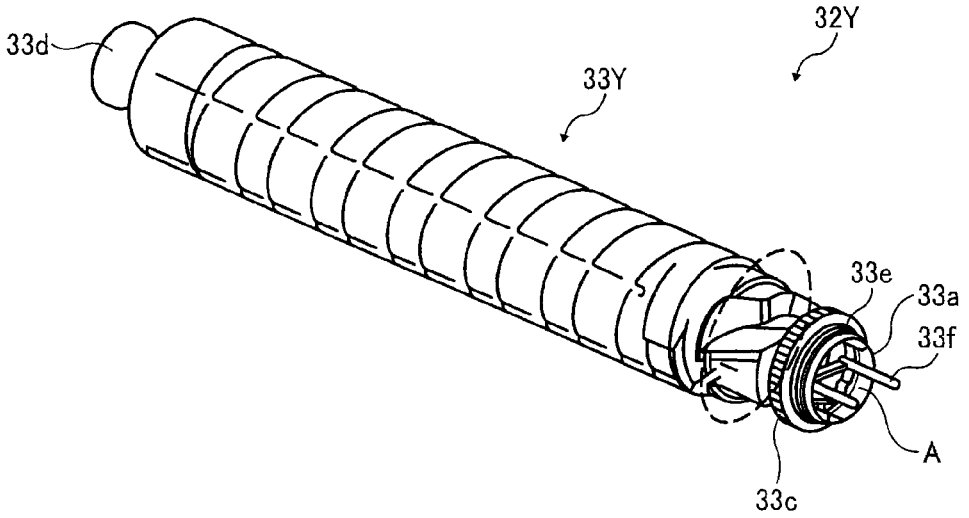


FIG. 11

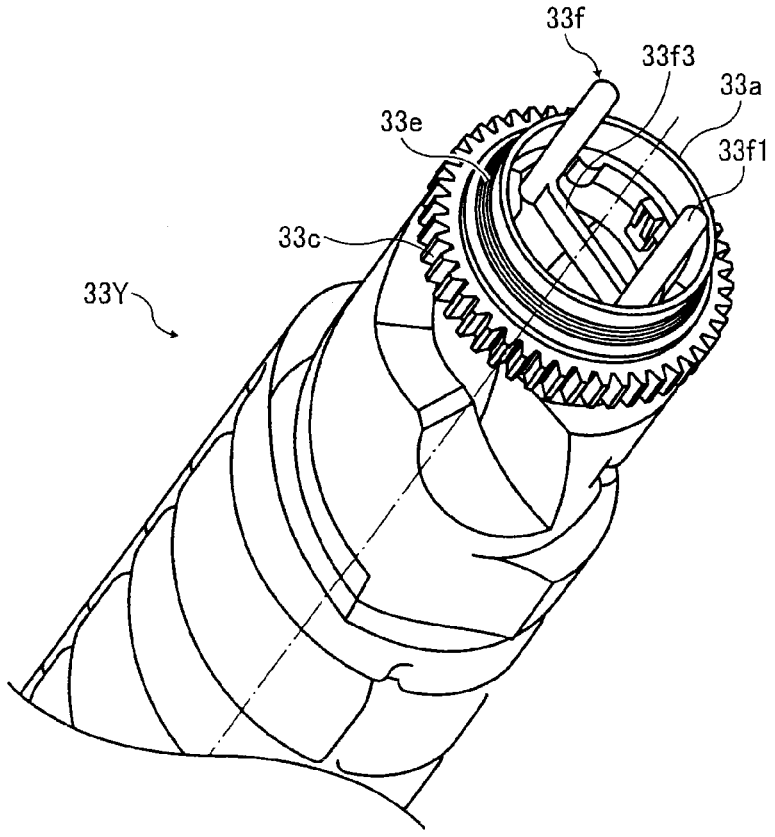


FIG. 12

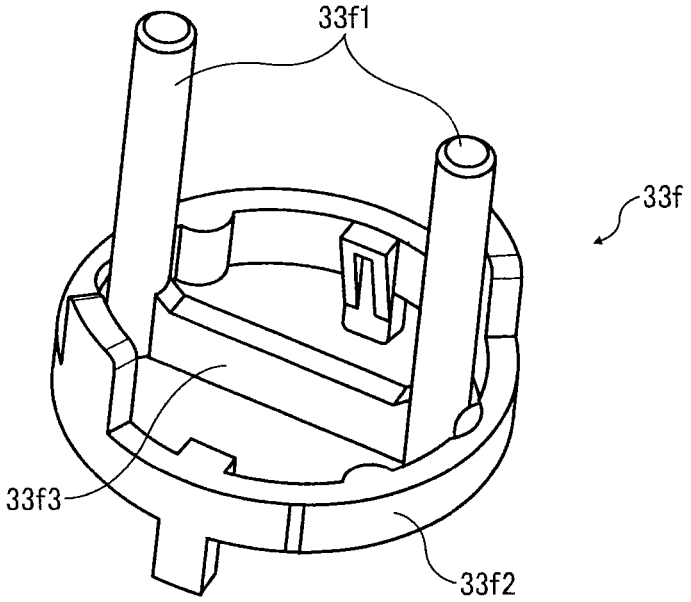


FIG. 13

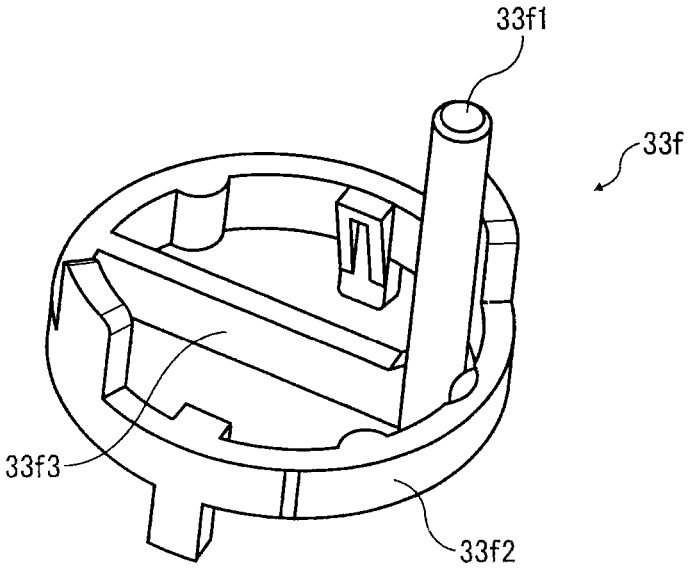


FIG. 14

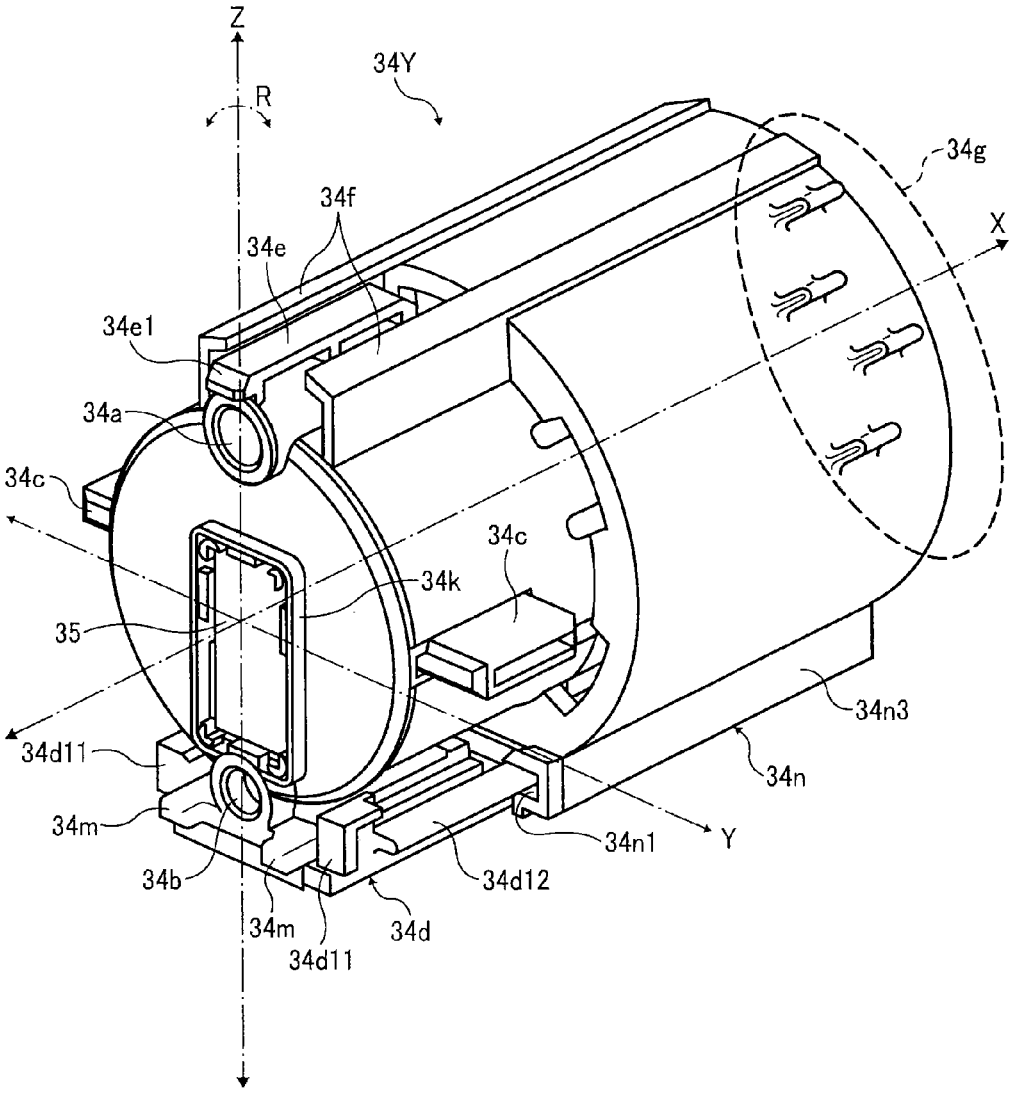
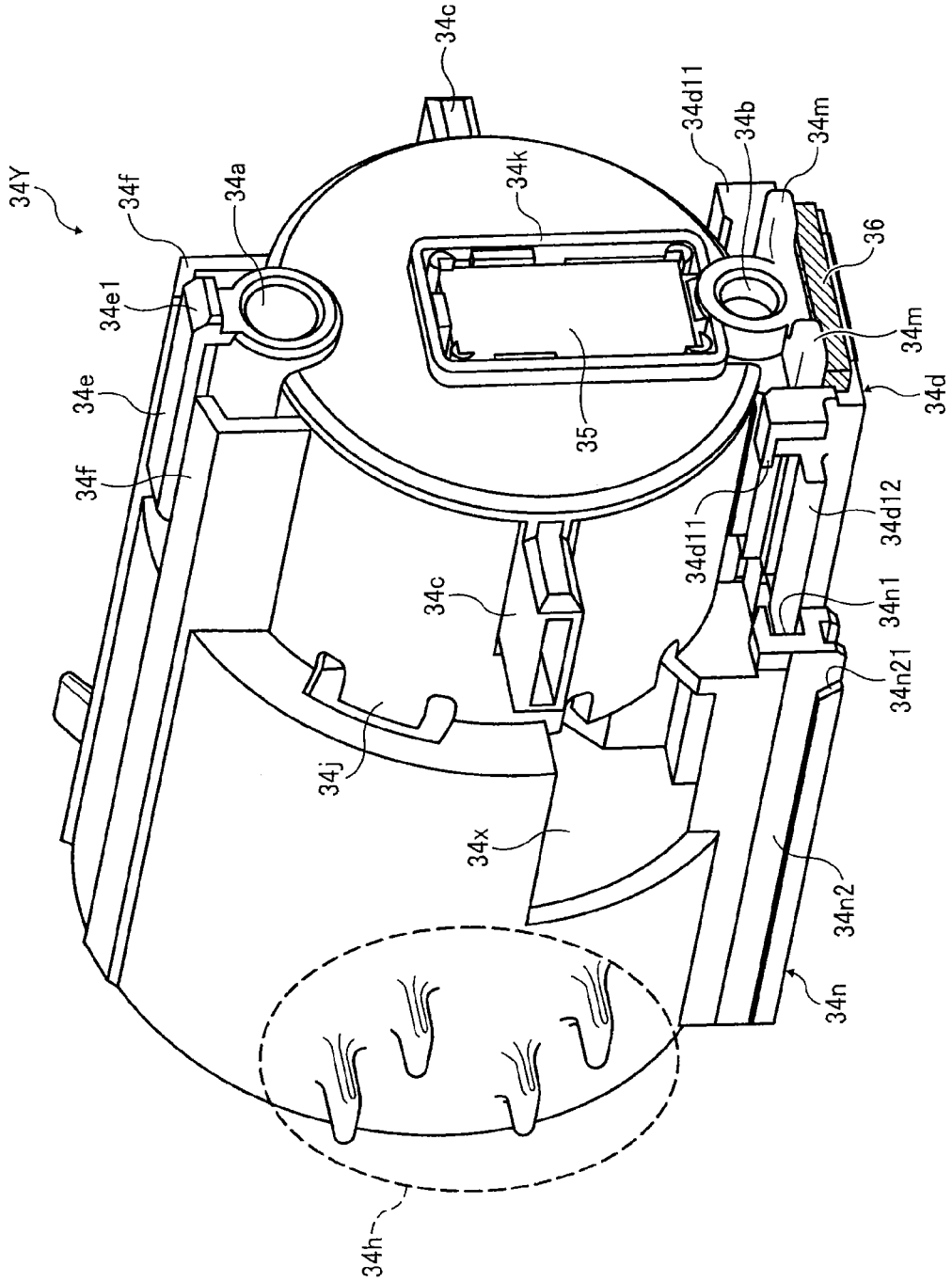

Z
R
34Y
34g
34f
X
34e
34e1
34a
34c
34c
34k
35
34n3
34d11
34n
34m
34n1
Y
34b
34d12
34m
34d
34d11

FIG. 15


34Y
34f
34a
34c
34k
34d11
34b
34m
36
34e1
34e
34f
35
34m
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34d12
34c
34n1
34n21
34j
34x
34n2
34n
34h

FIG. 16

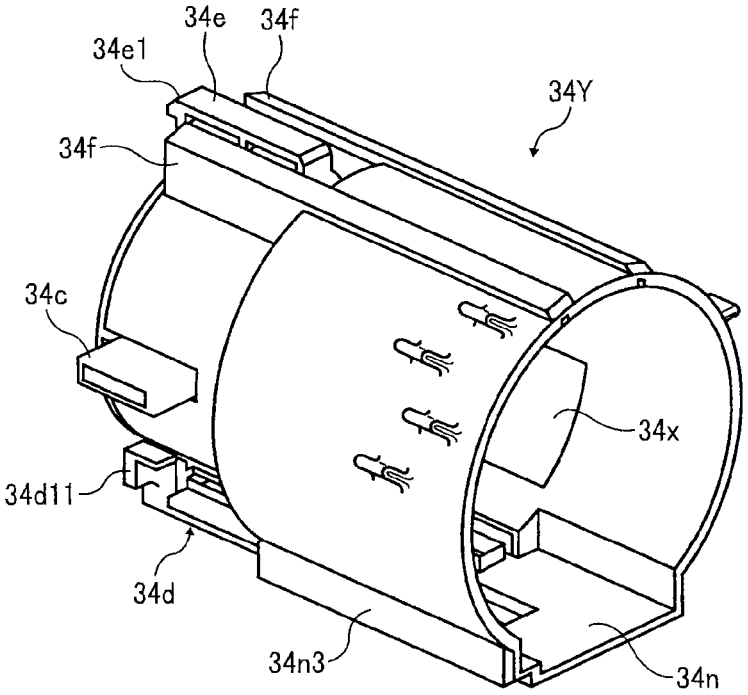

34e
34f
34e1
34Y
34f
34c
34x
34d11
34d
34n3
34n

FIG. 17

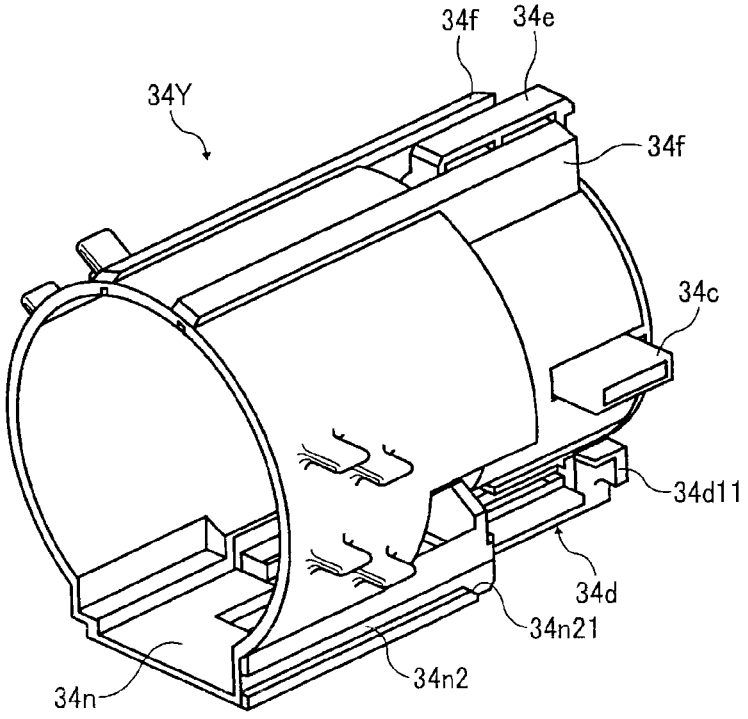

34f
34e
34Y
34f
34c
34d11
34d
34n21
34n2
34n

FIG. 18

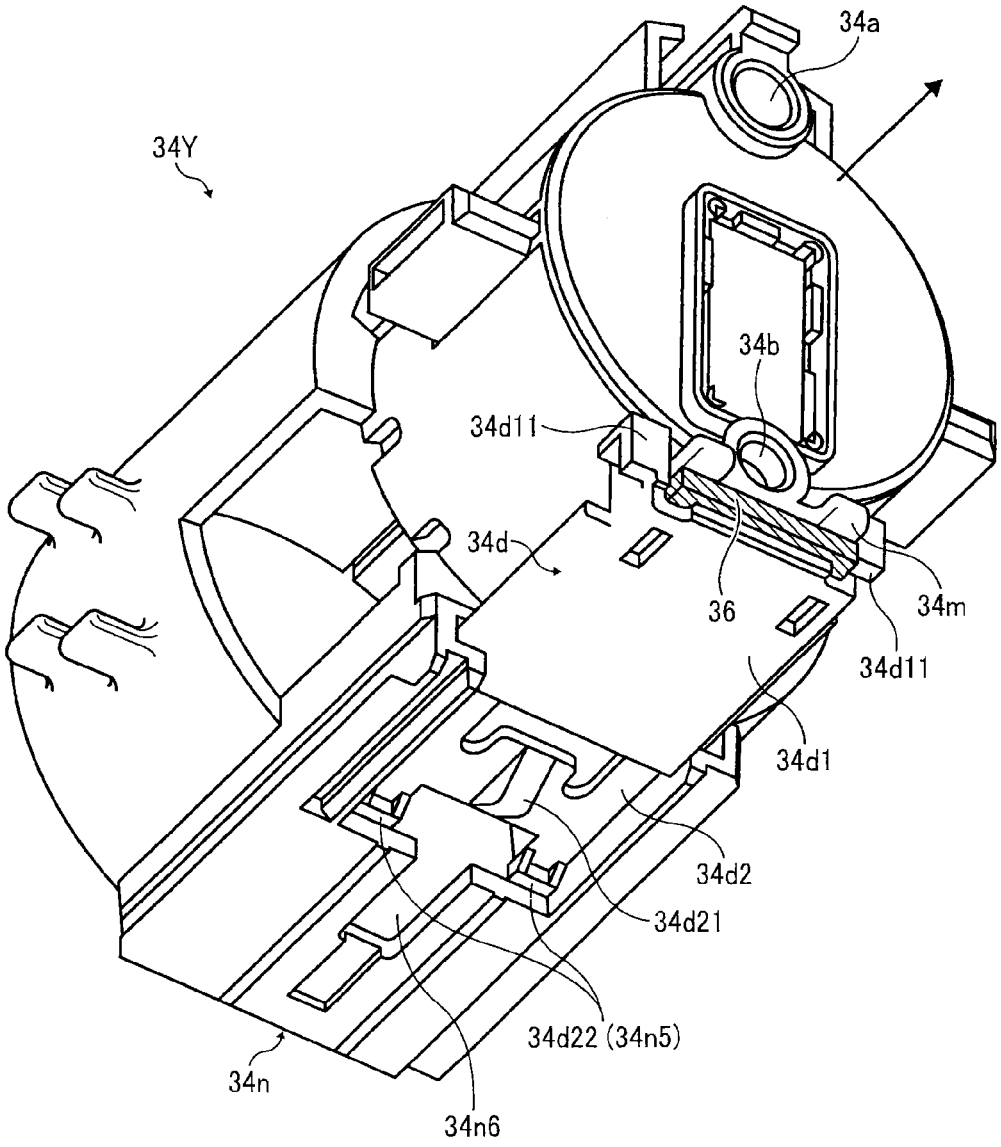

34a
34Y
34b
34d11
34d
36
34m
34d11
34d1
34d2
34d21
34d22 (34n5)
34n
34n6

FIG. 20

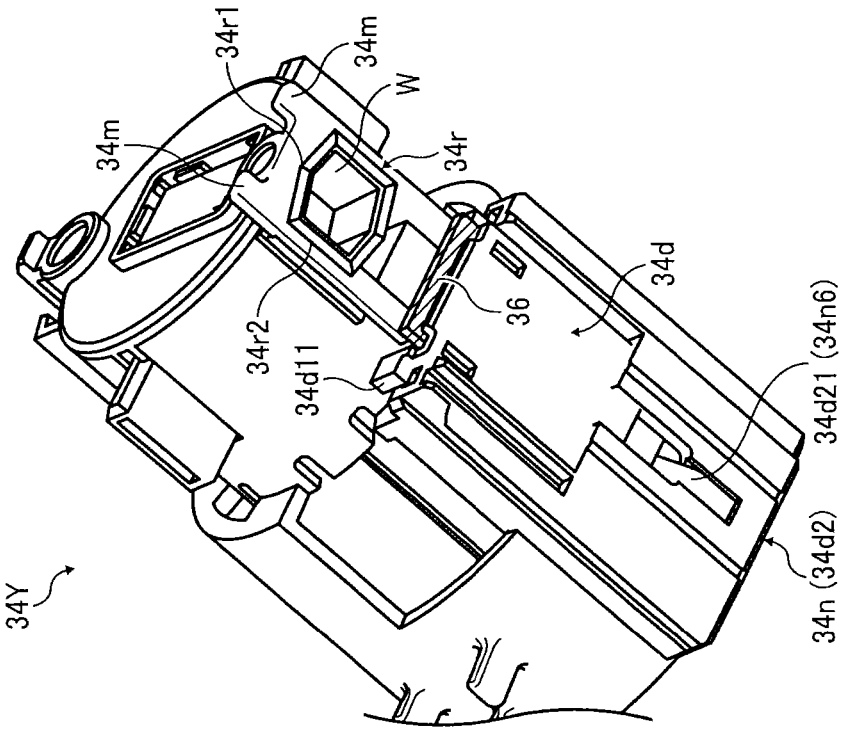

34r1
34m
W
34m
34r
34d
36
34r2
34d11
34d21 (34n6)
34n (34d2)
34Y

FIG. 19

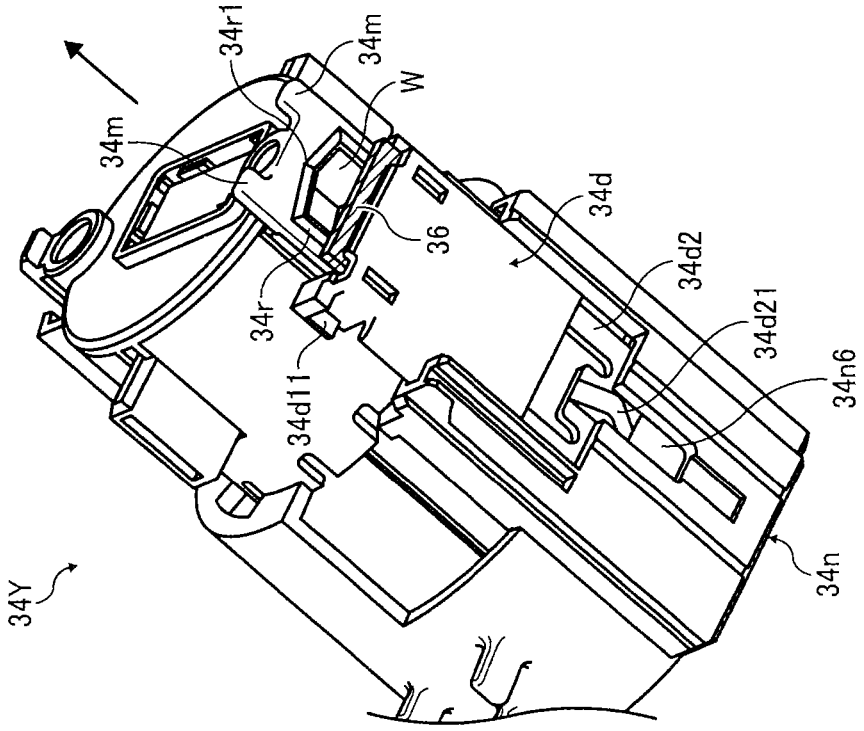

34r1
34m
W
34m
34d
36
34d2
34r
34d21
34n6
34d11
34n
34Y

FIG. 21A

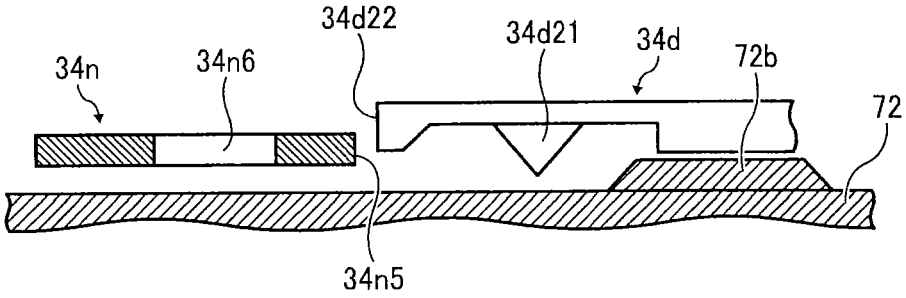


FIG. 21B

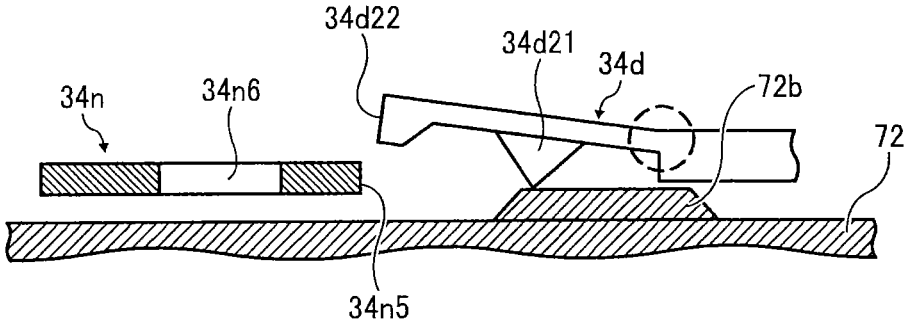


FIG. 21C

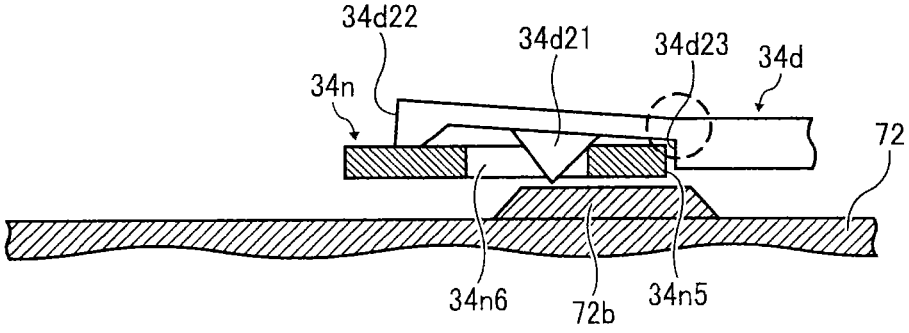


FIG. 22

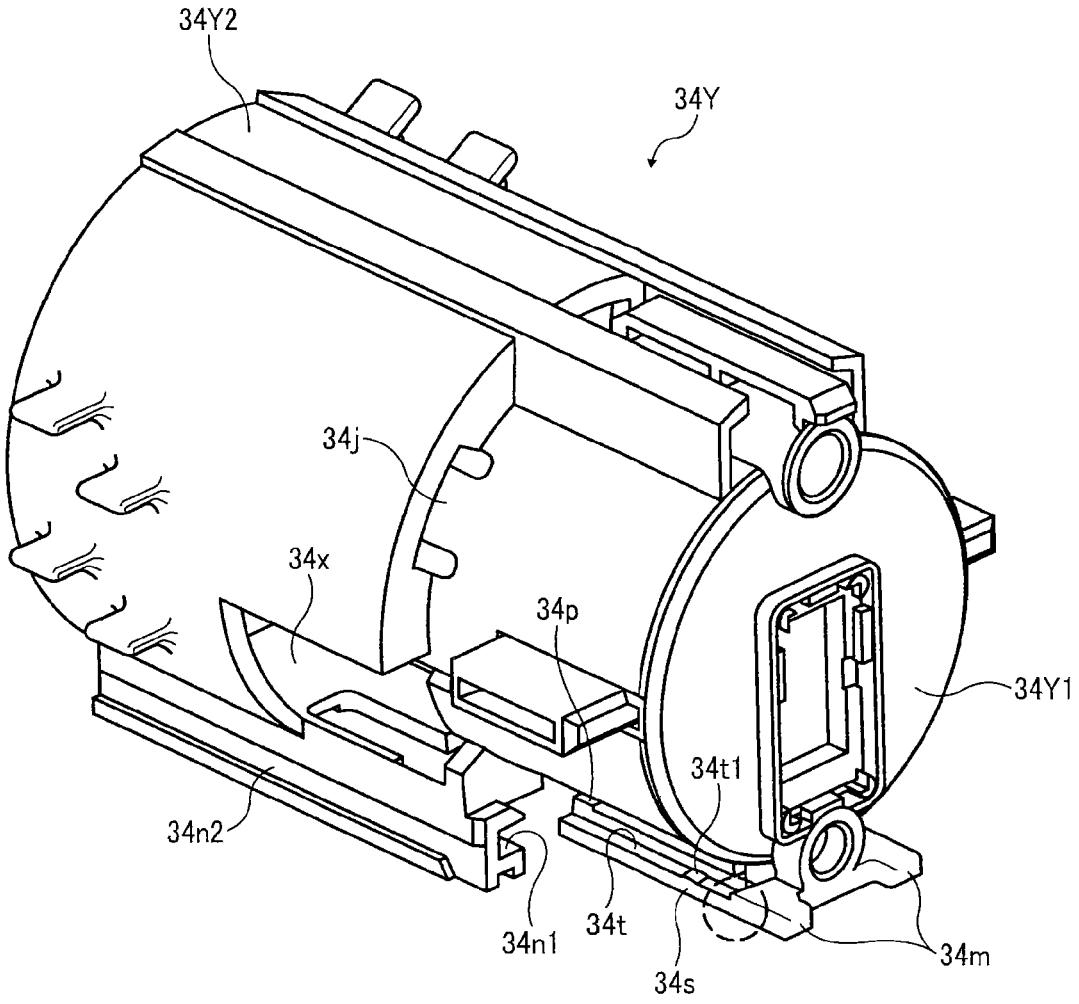


FIG. 24

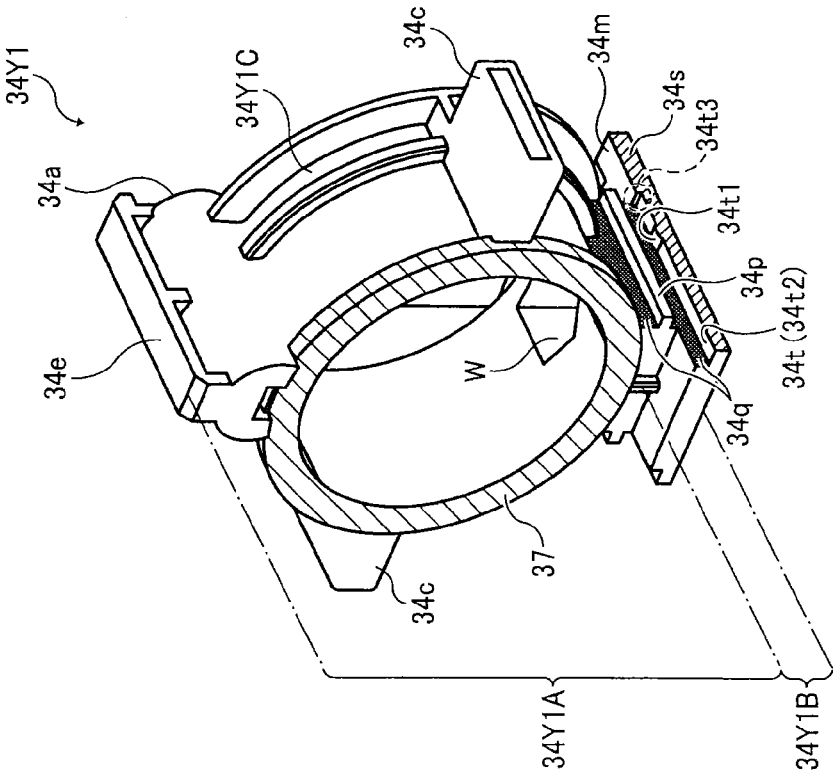

34Y1
34Y1C
34c
34m
34s
34t3
34a
34t1
34p
34e
W
34t (34t2)
34q
37
34c
34Y1A
34Y1B

FIG. 23

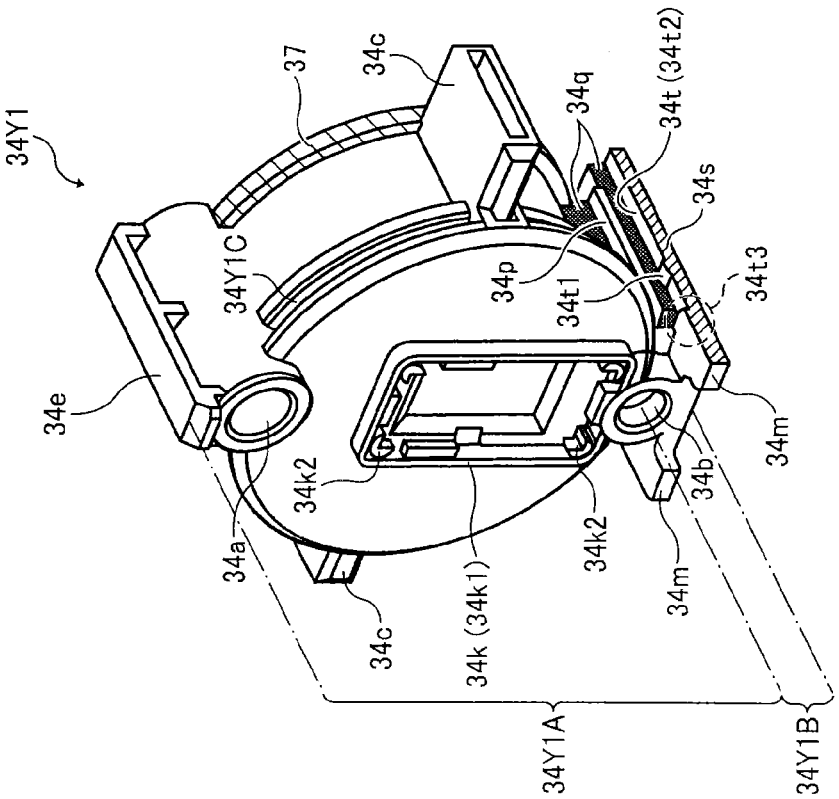

34Y1
37
34c
34q
34t (34t2)
34s
34Y1C
34p
34t1
34t3
34e
34m
34k2
34b
34a
34k2
34m
34c
34k (34k1)
34Y1A
34Y1B

FIG. 25

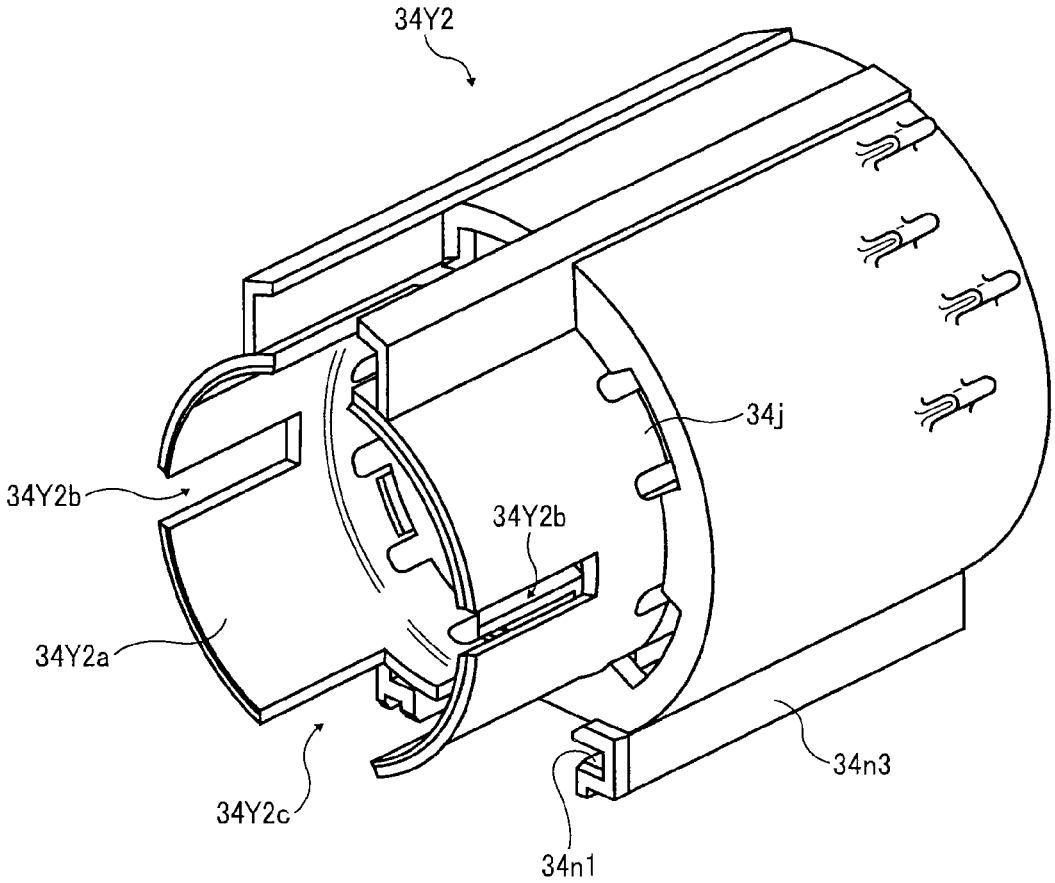


FIG. 26

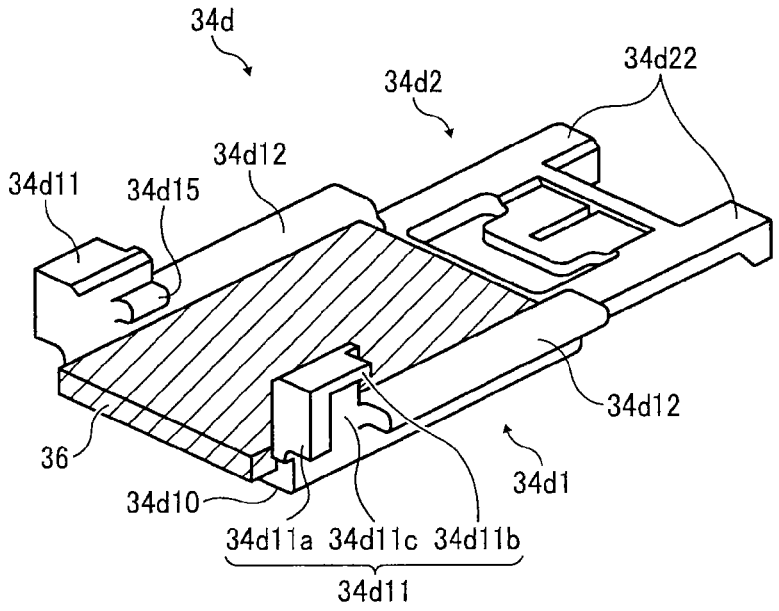

34d
34d2
34d22
34d12
34d11
34d15
34d12
36
34d1
34d10
34d11a
34d11c
34d11b
34d11

FIG. 27

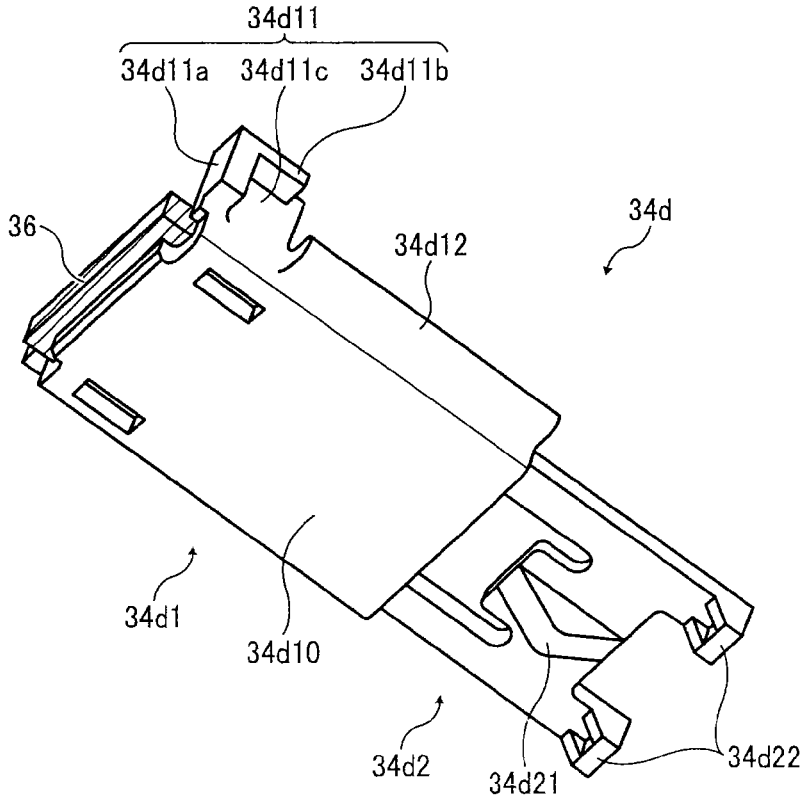

34d11
34d11a
34d11c
34d11b
36
34d12
34d
34d1
34d10
34d2
34d21
34d22

FIG. 28A

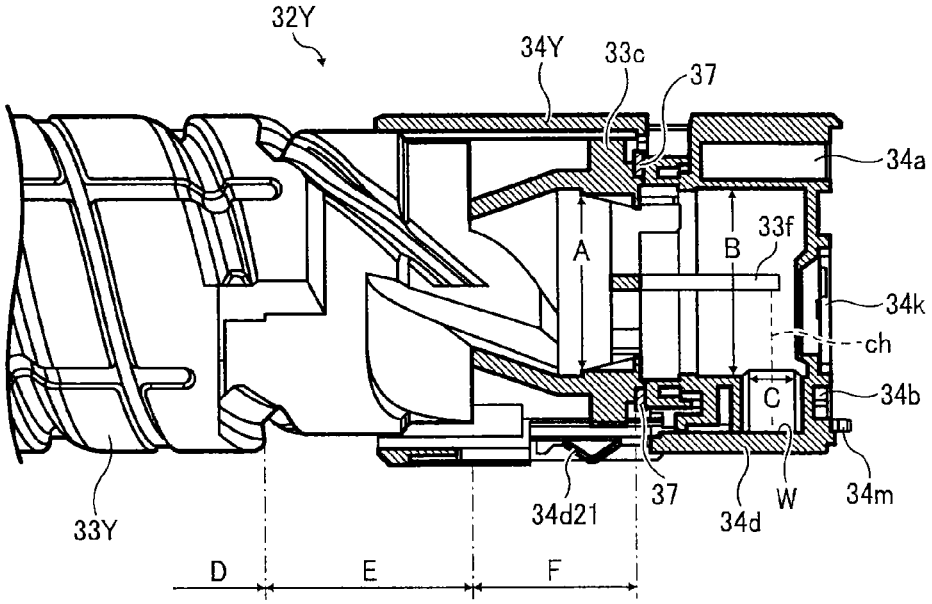


FIG. 28B

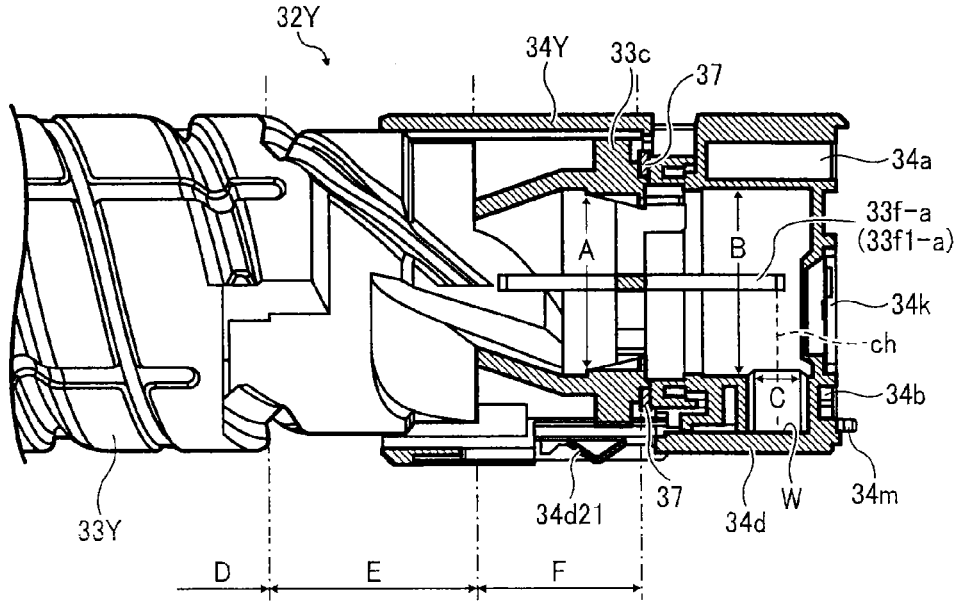
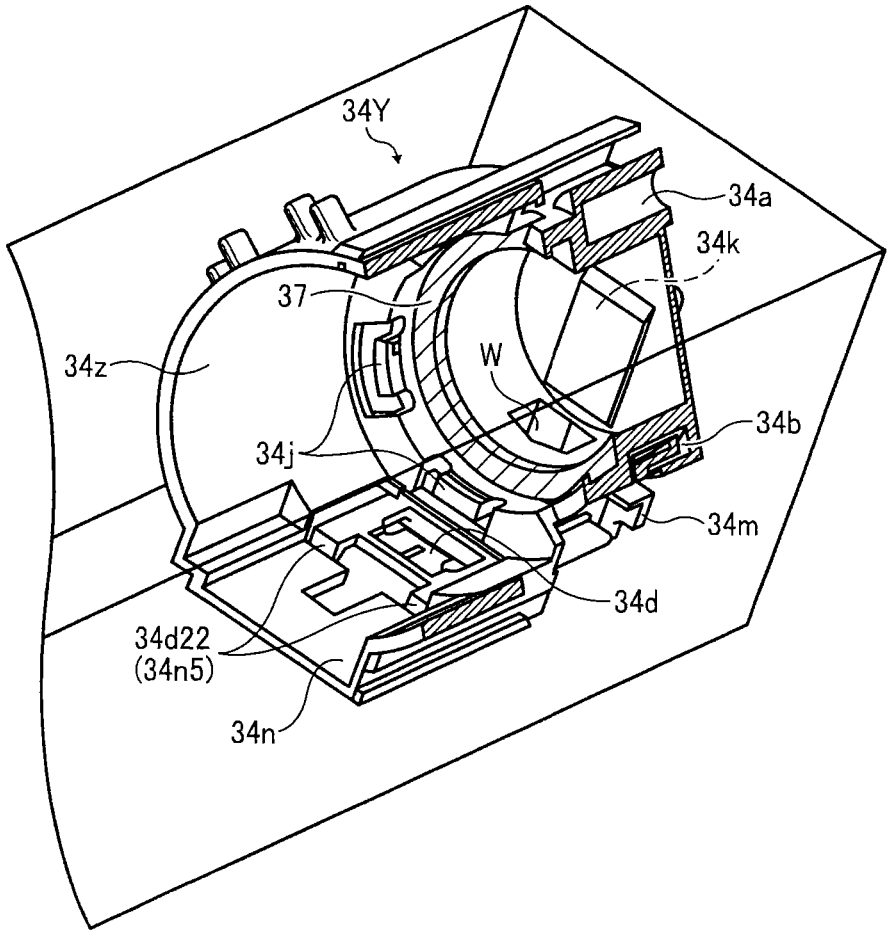


FIG. 29



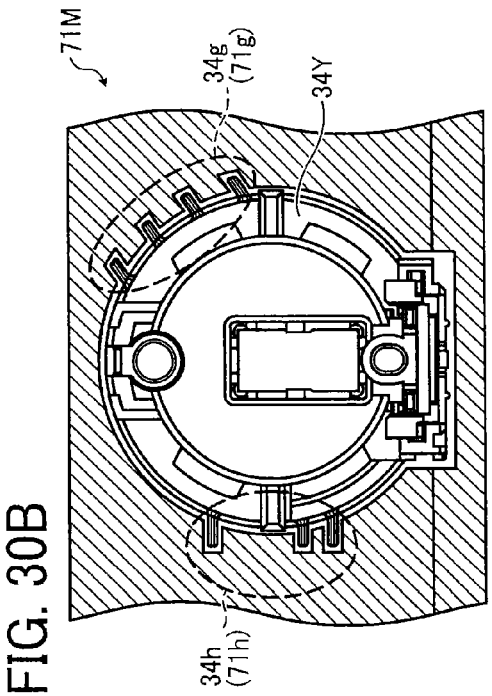


FIG. 30B

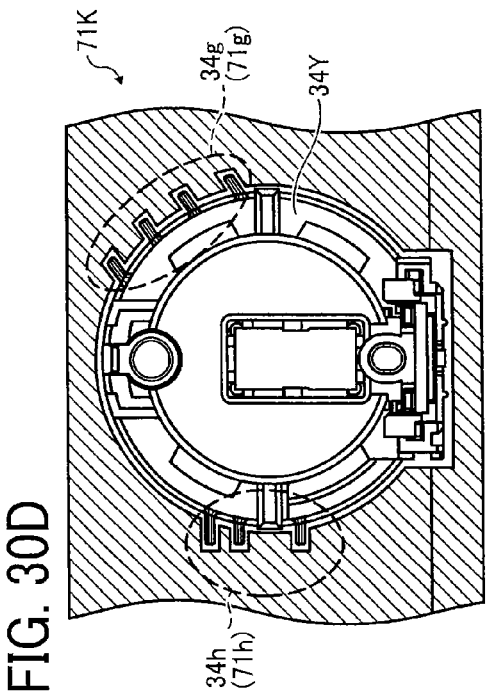


FIG. 30D

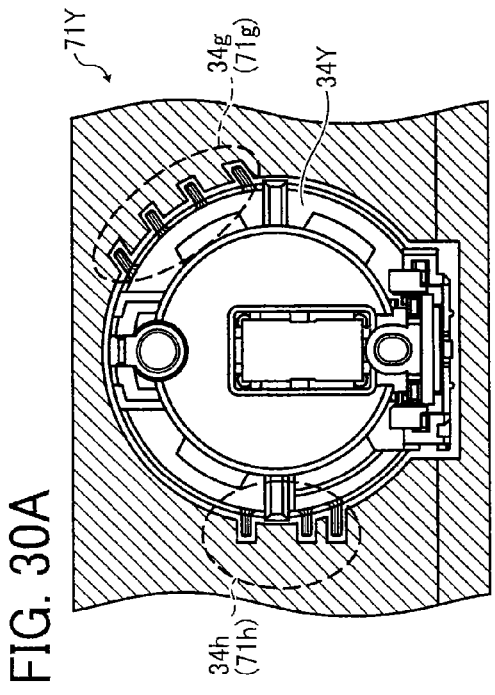


FIG. 30A

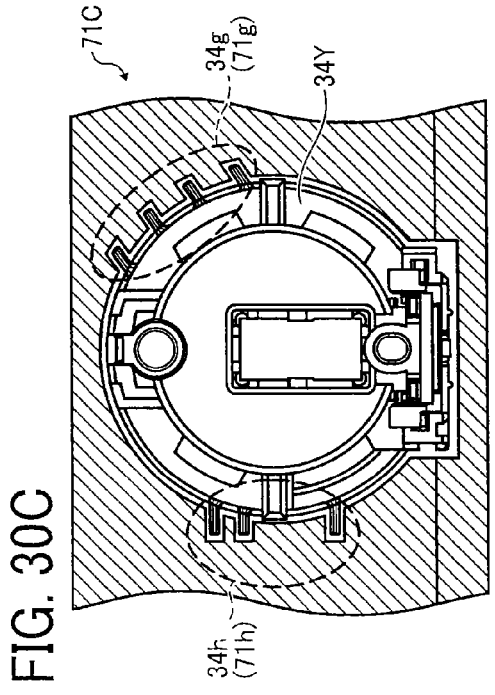


FIG. 30C

FIG. 31A

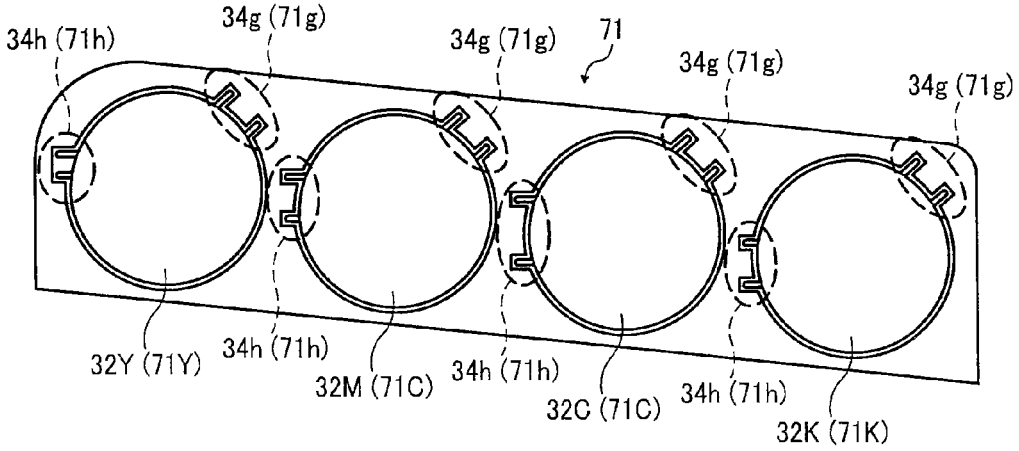


FIG. 31B

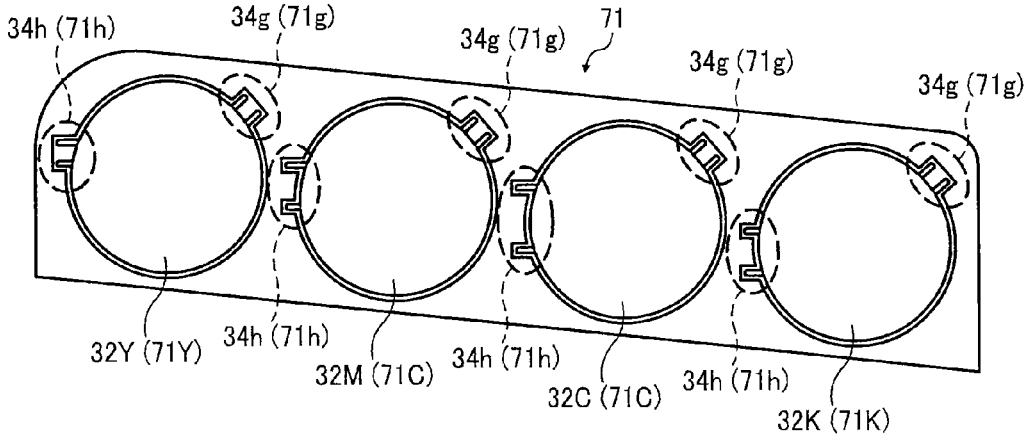


FIG. 31C

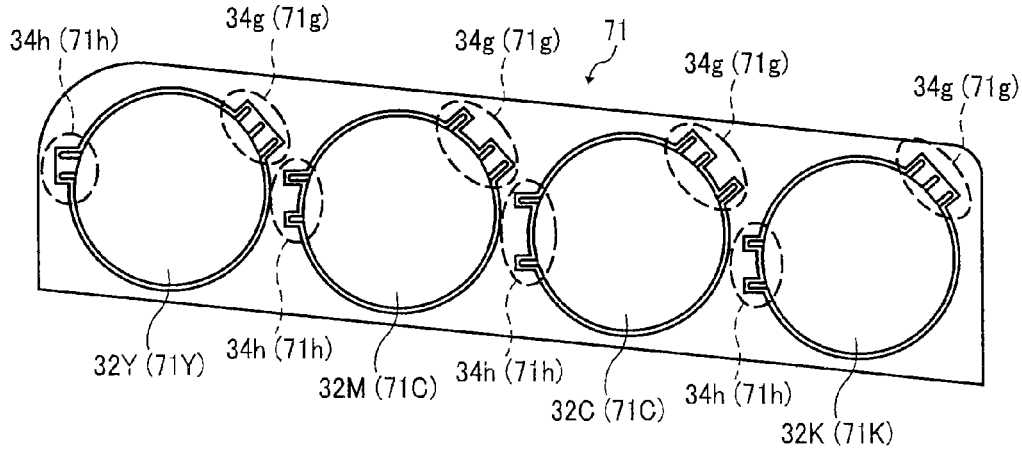
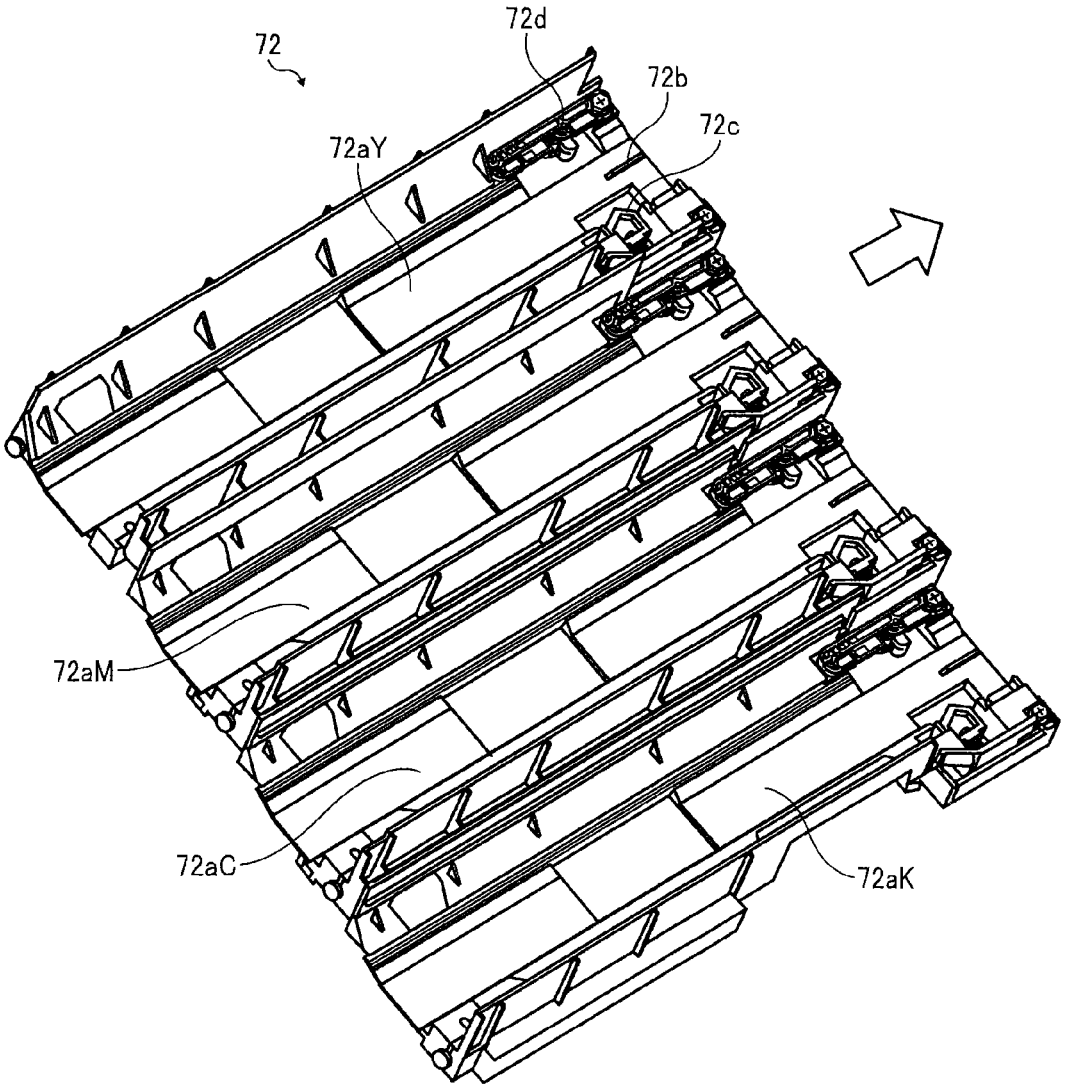


FIG. 32



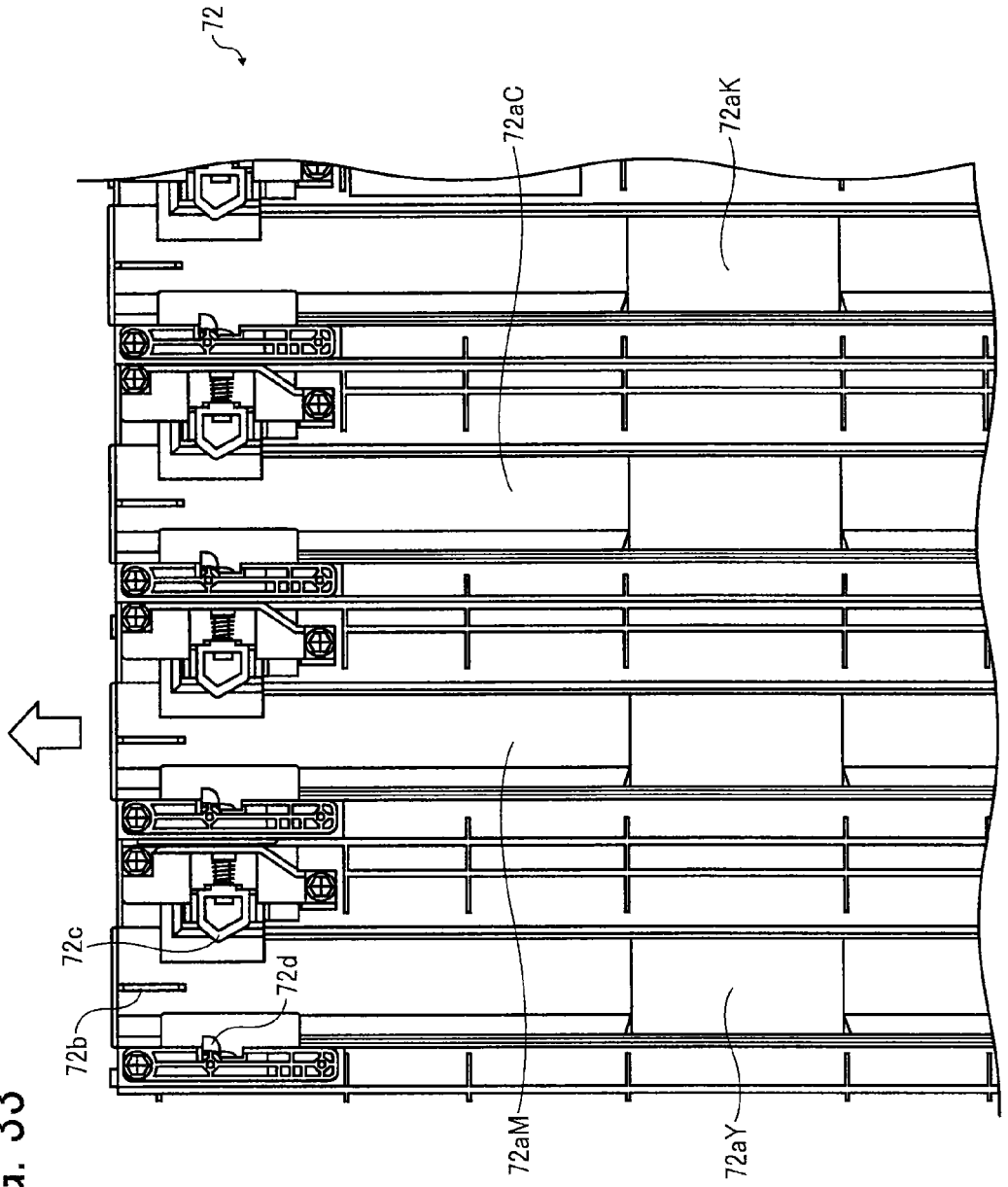


FIG. 33

FIG. 34

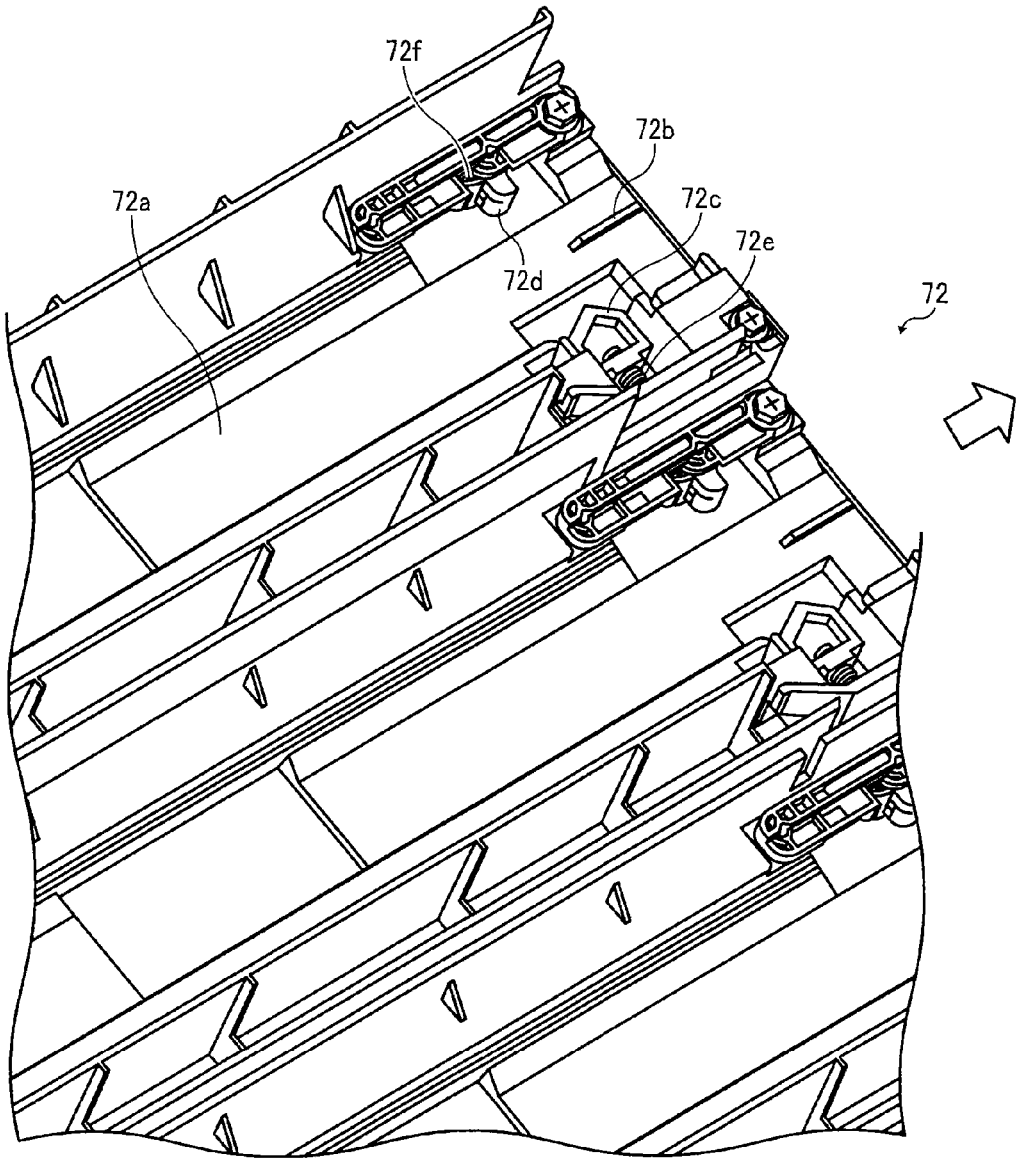
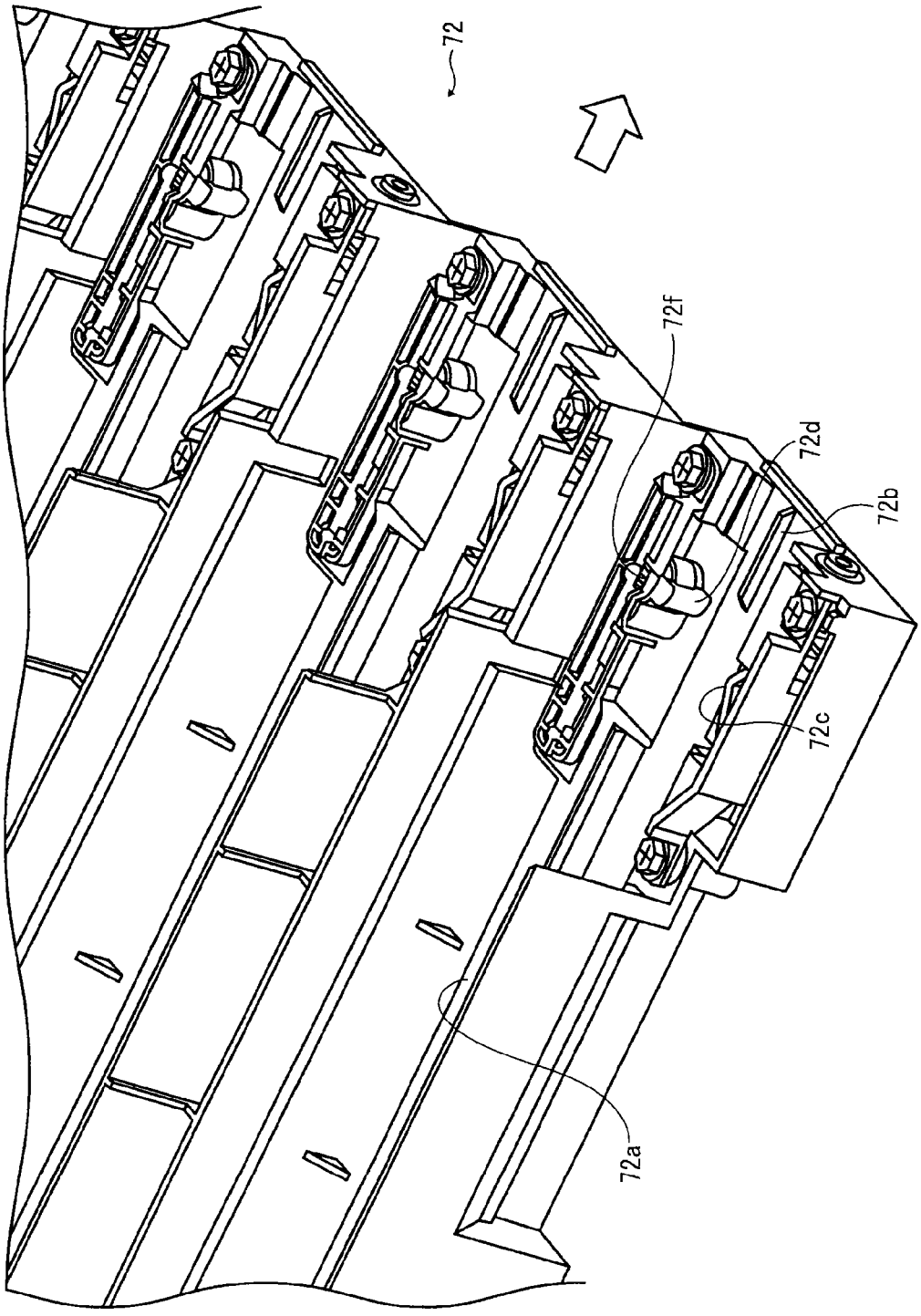


FIG. 35



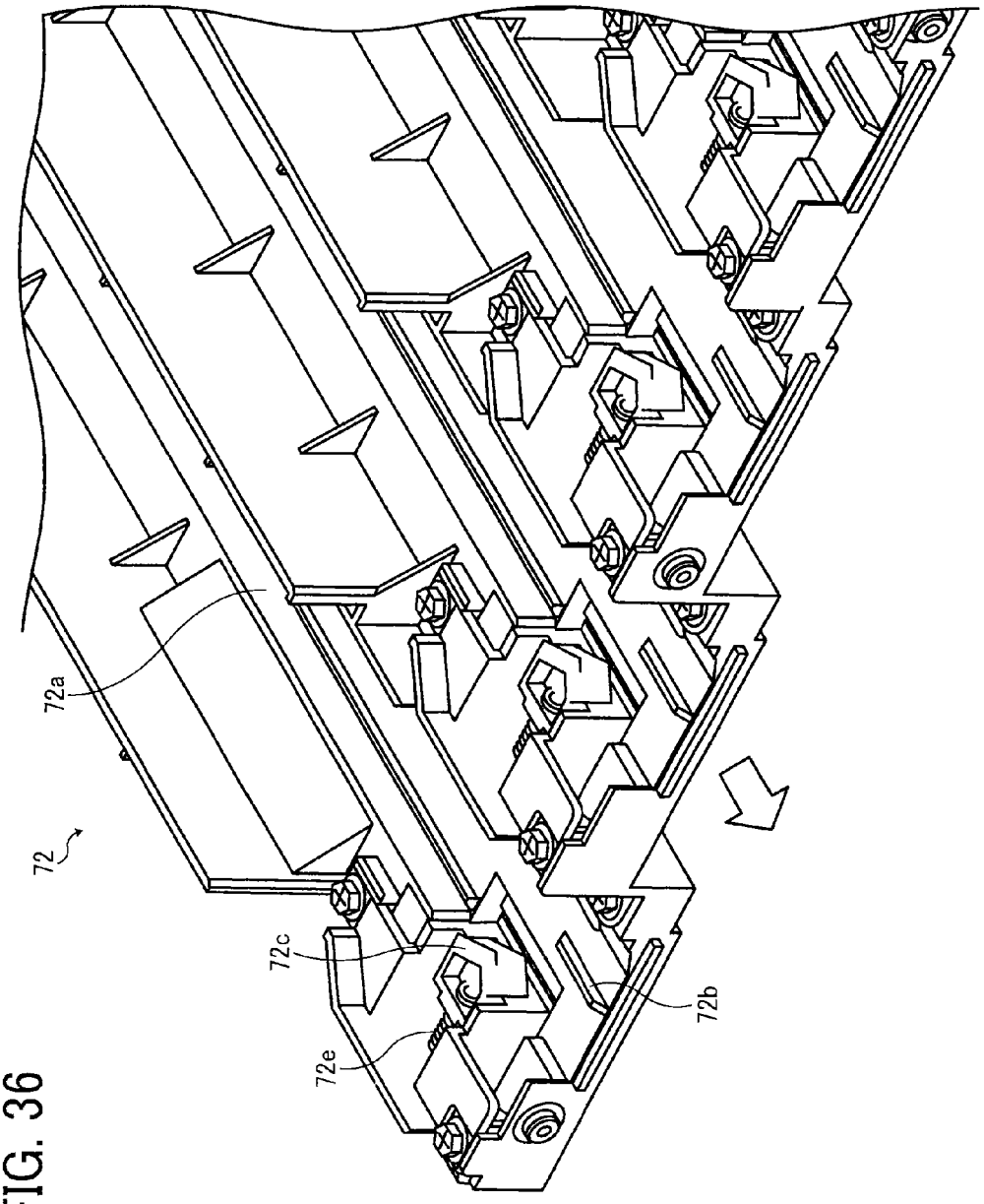


FIG. 36

FIG. 37

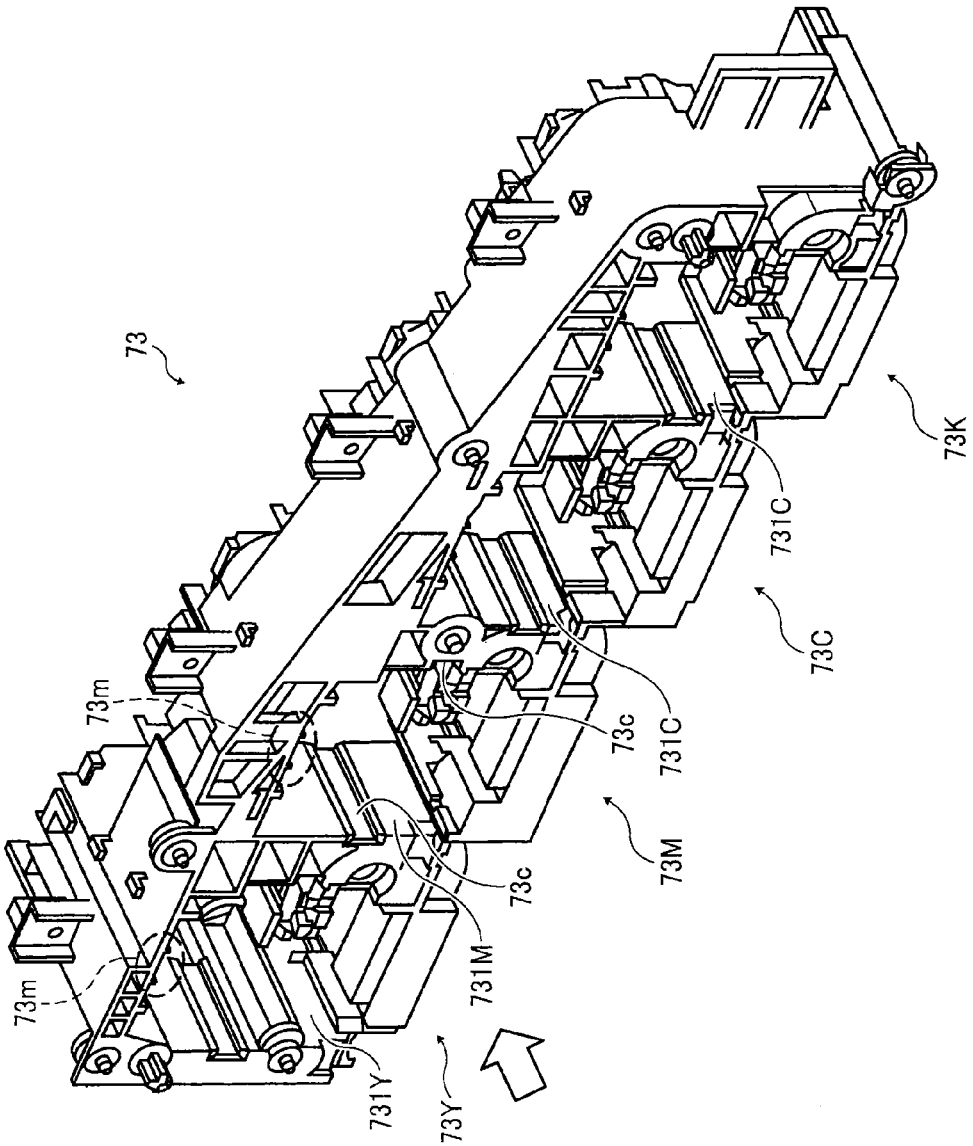
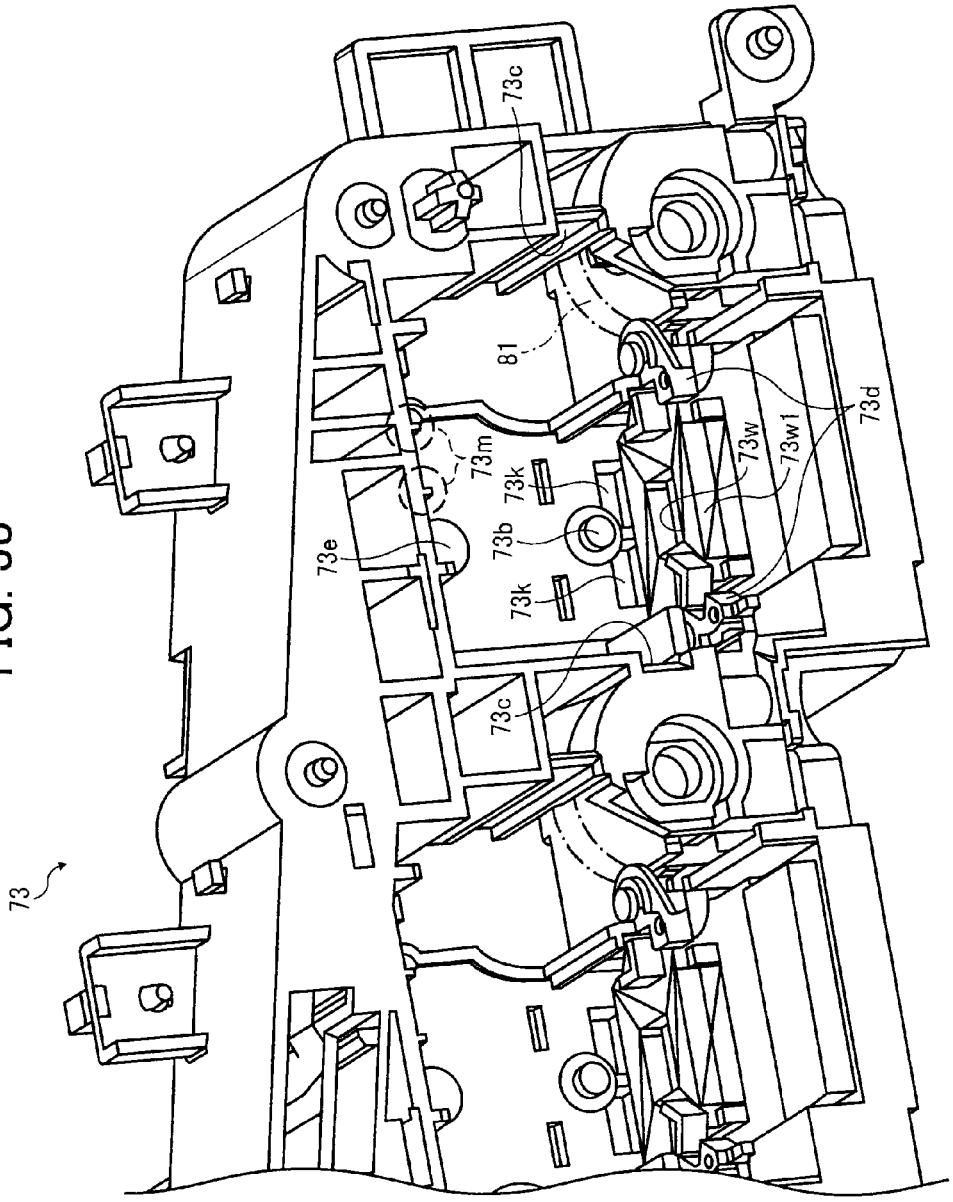


FIG. 38



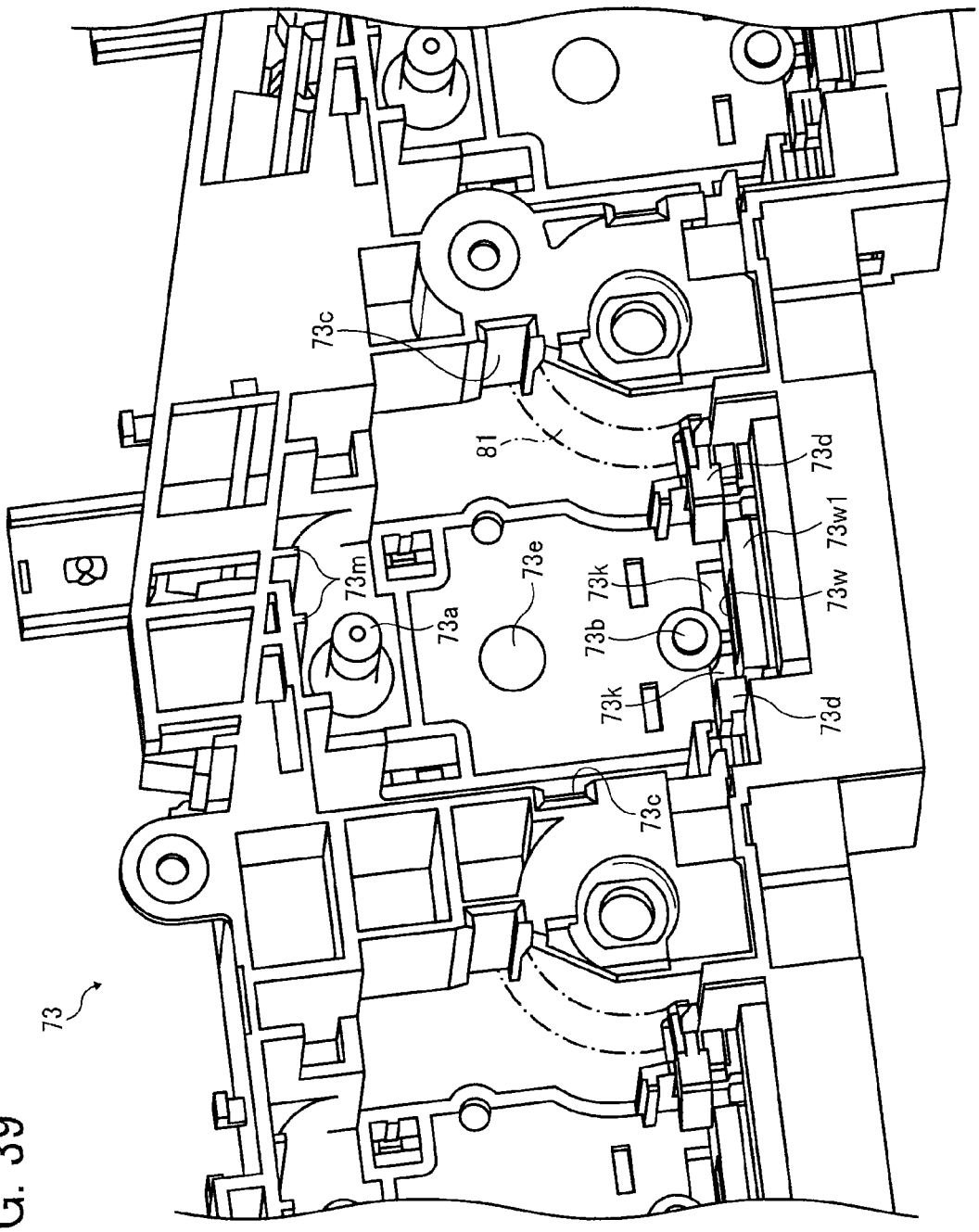


FIG. 39

FIG. 41

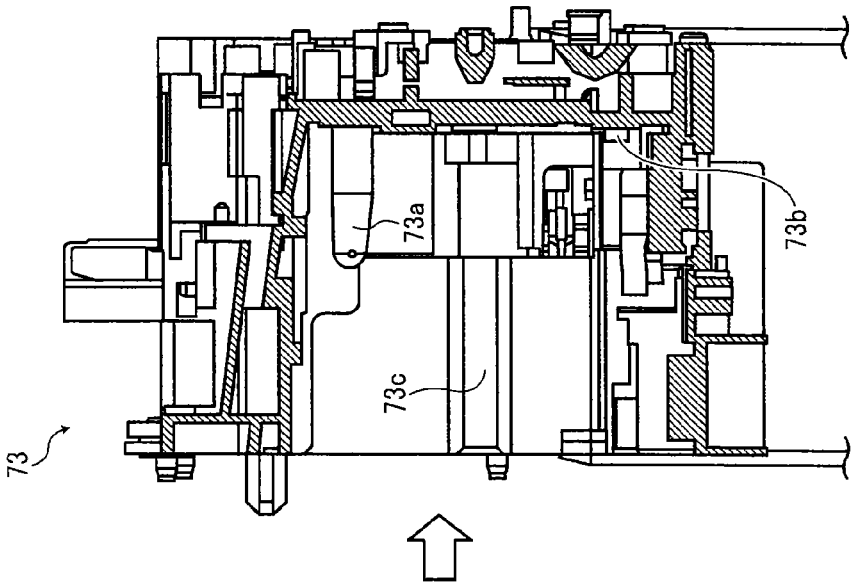
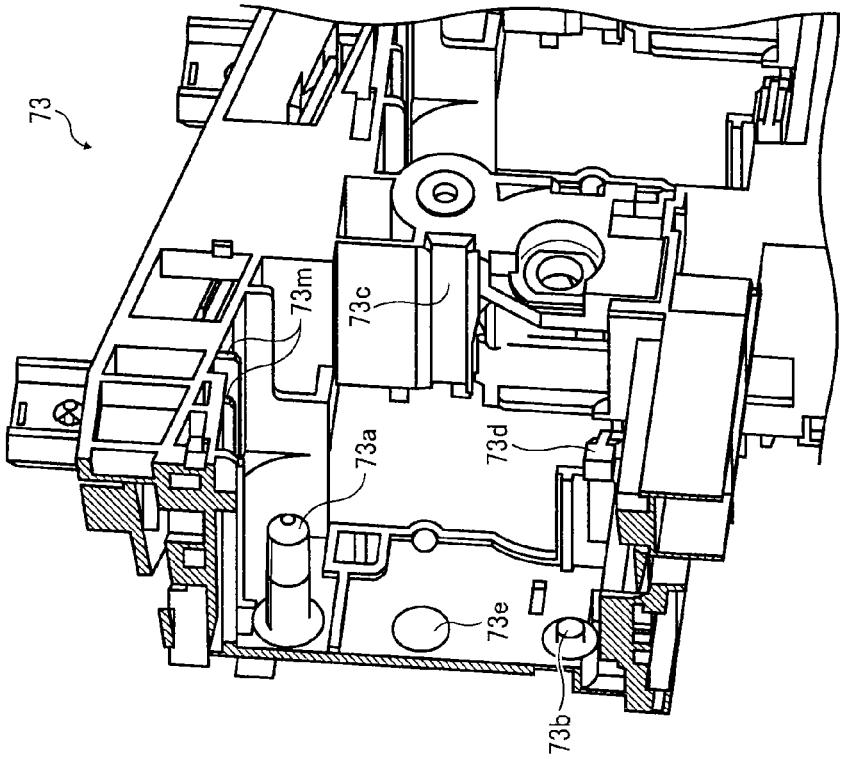


FIG. 40



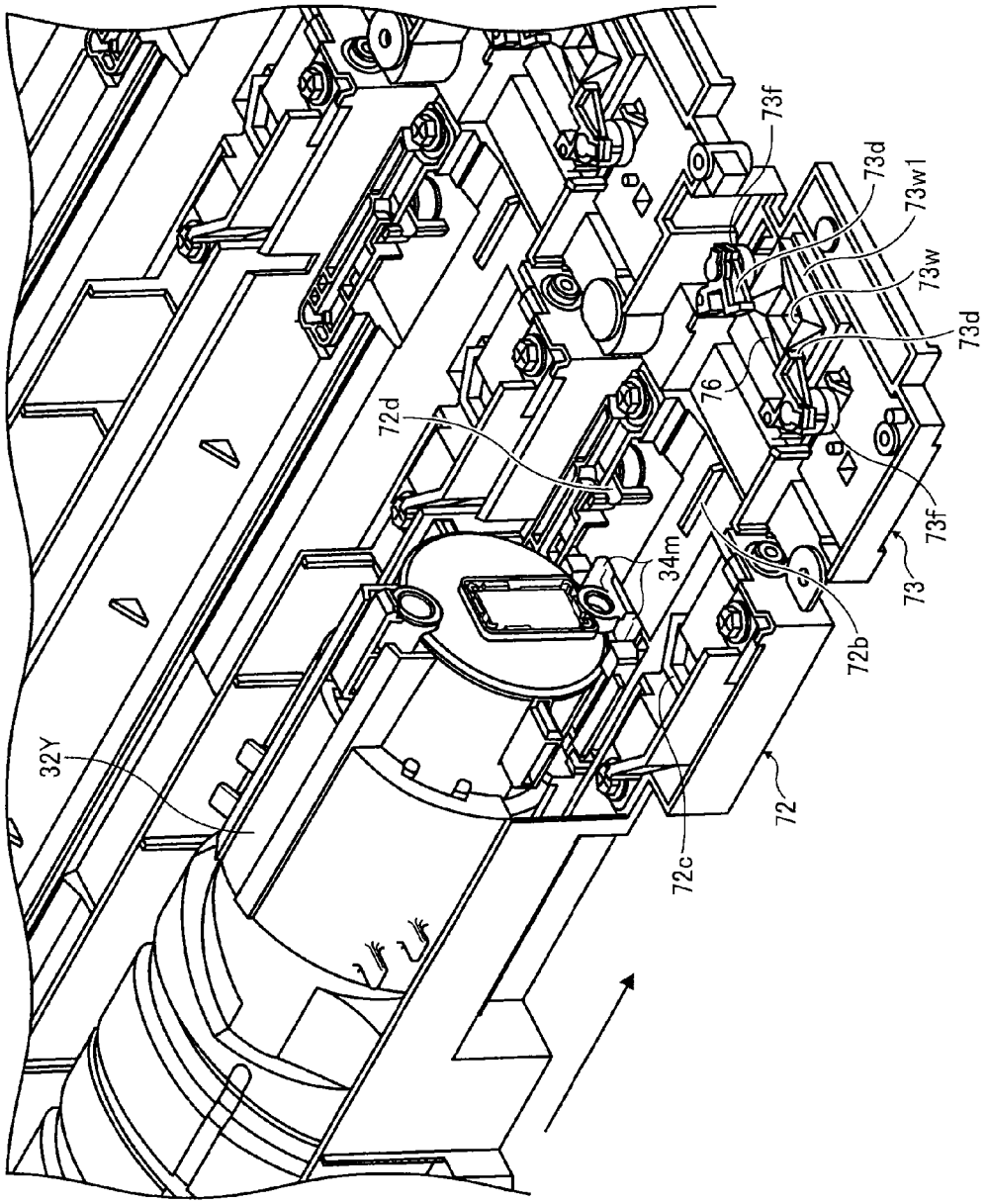


FIG. 42

FIG. 43

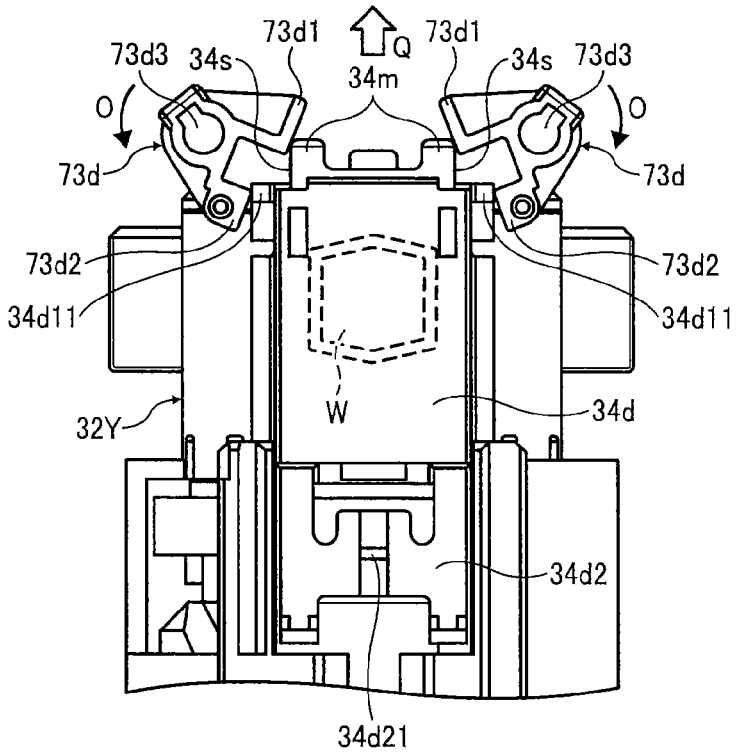

73d1
Q
73d1
73d3
34s
34m
34s
73d3
O
O
73d
73d
73d2
73d2
34d11
34d11
W
32Y
34d
34d2
34d21

FIG. 44

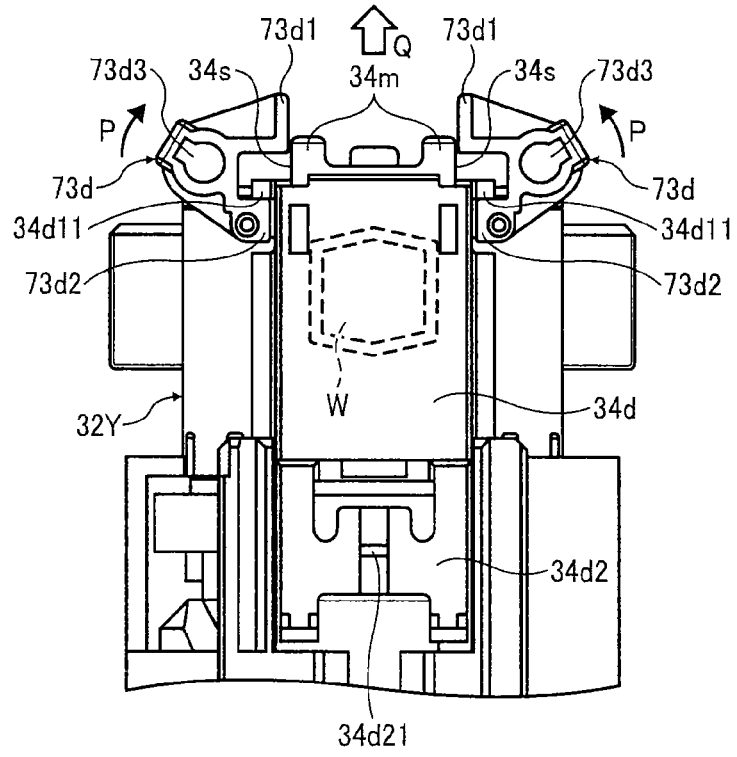
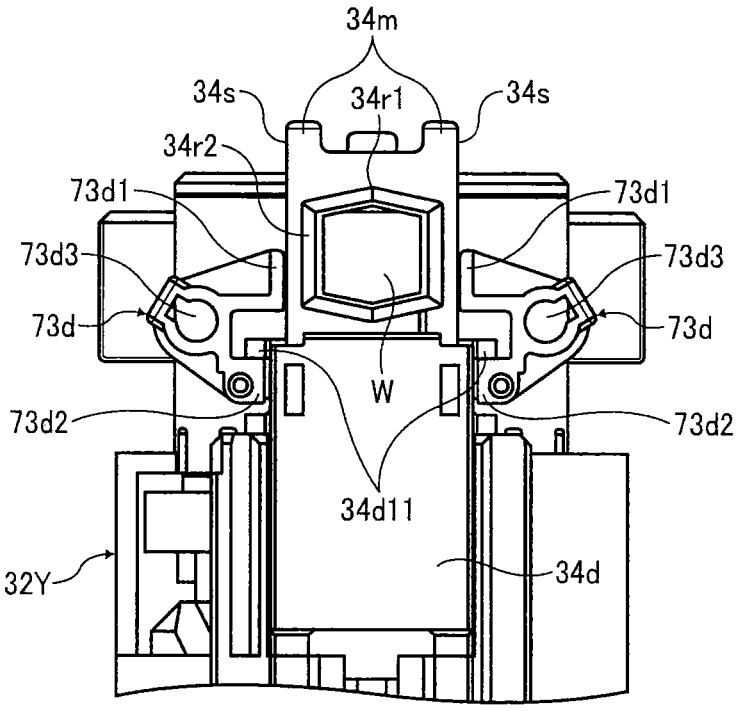

73d1
Q
73d1
73d3
34s
34m
34s
73d3
P
P
73d
73d
34d11
34d11
73d2
73d2
W
32Y
34d
34d2
34d21

FIG. 45


34m
34s
34r1
34s
34r2
73d1
73d1
73d3
73d3
73d
73d
W
73d2
73d2
34d11
32Y
34d

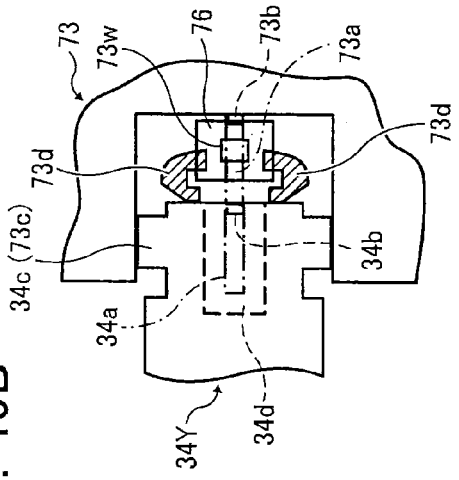


FIG. 46B

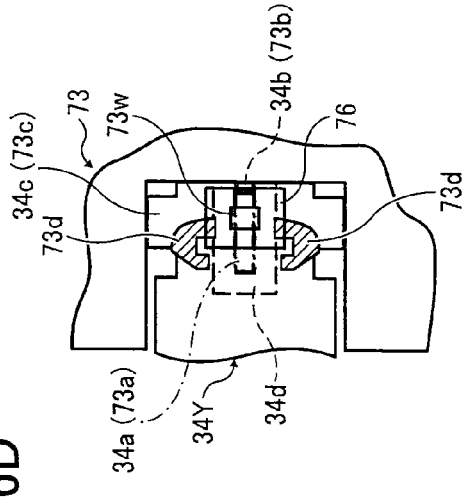


FIG. 46D

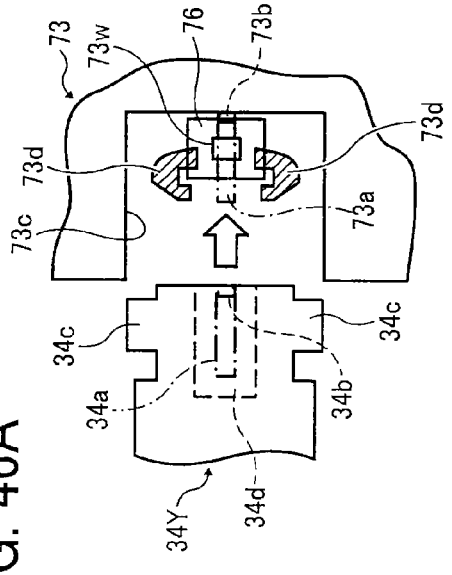


FIG. 46A

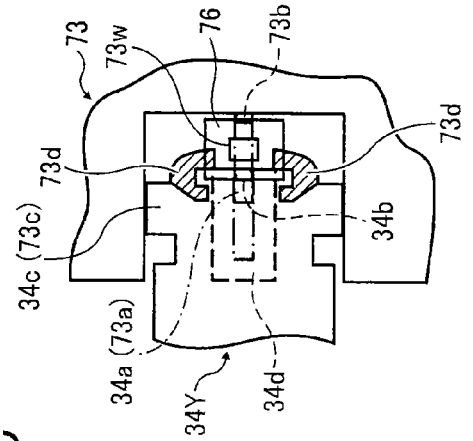


FIG. 46C

FIG. 47

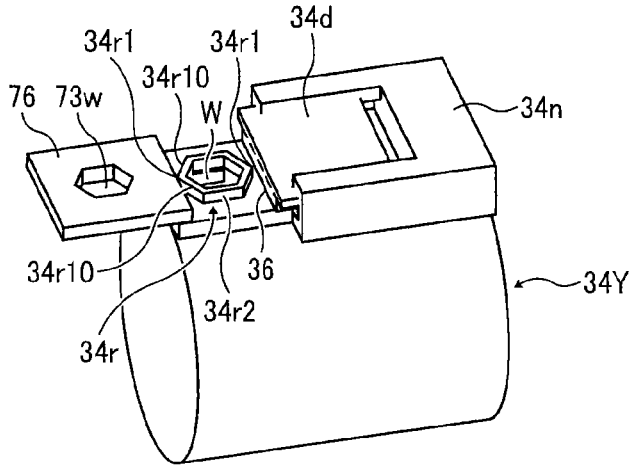


FIG. 48A

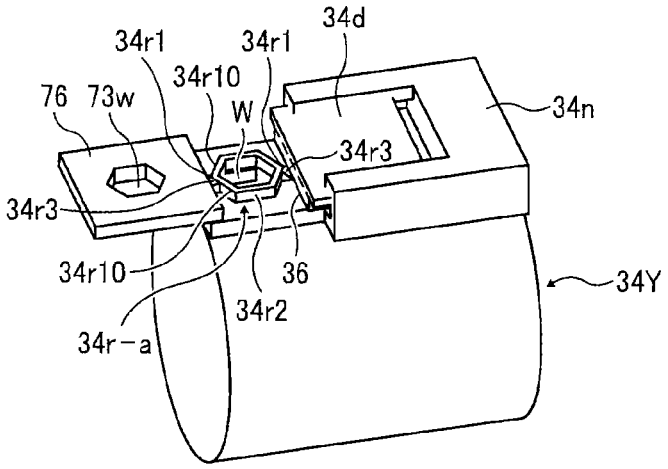


FIG. 48B

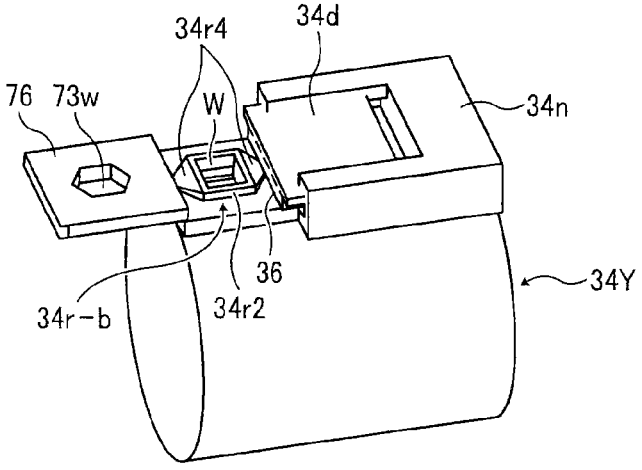


FIG. 49

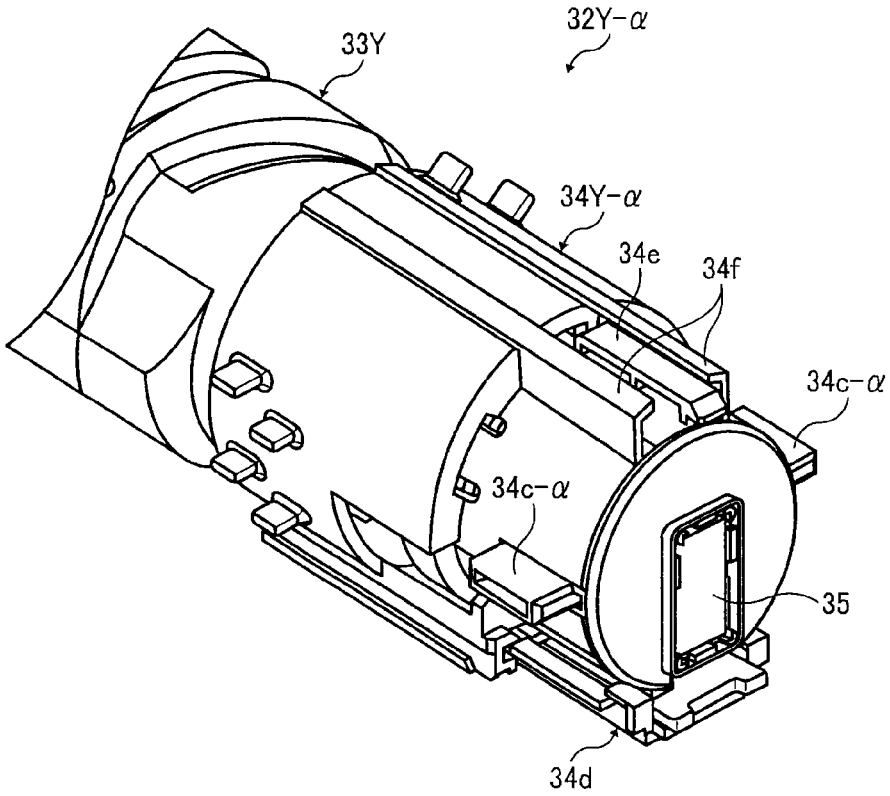

32Y-α
33Y
34Y-α
34e
34f
34c-α
34c-α
35
34d

FIG. 50

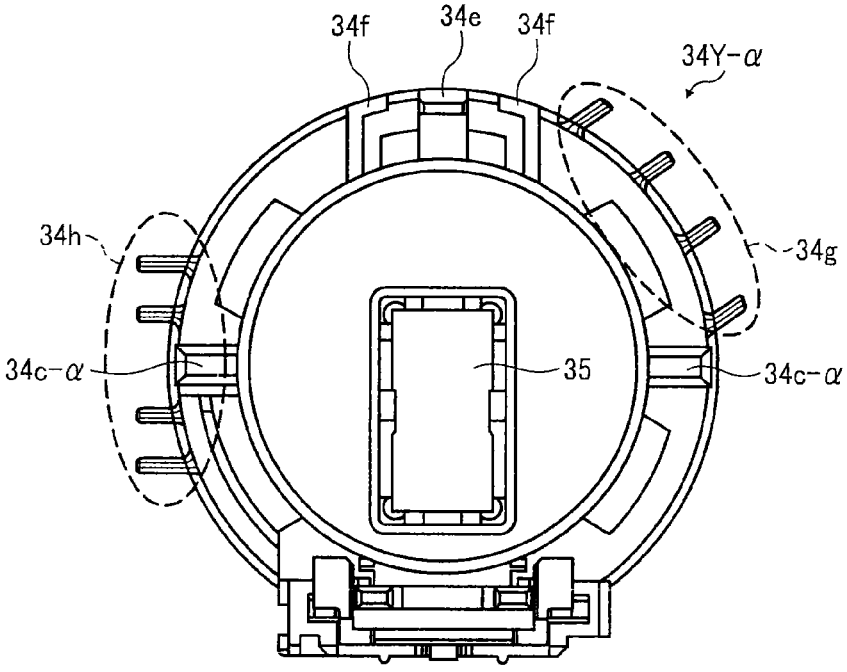

34f
34e
34f
34Y-α
34h
34g
34c-α
35
34c-α

FIG. 51

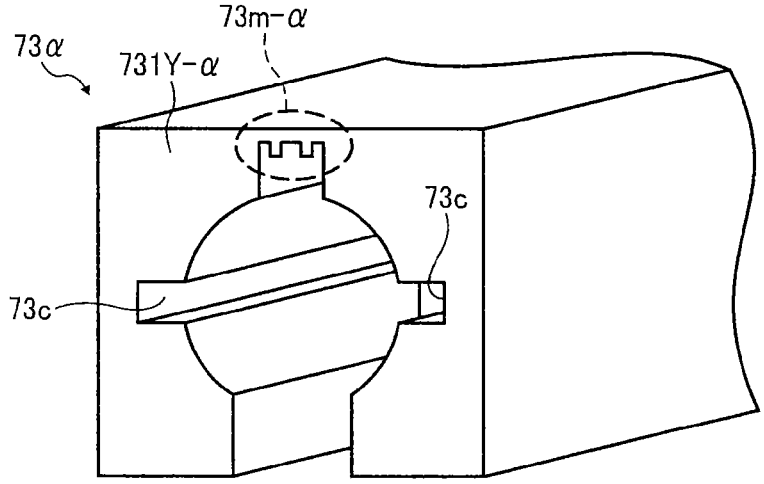


FIG. 52

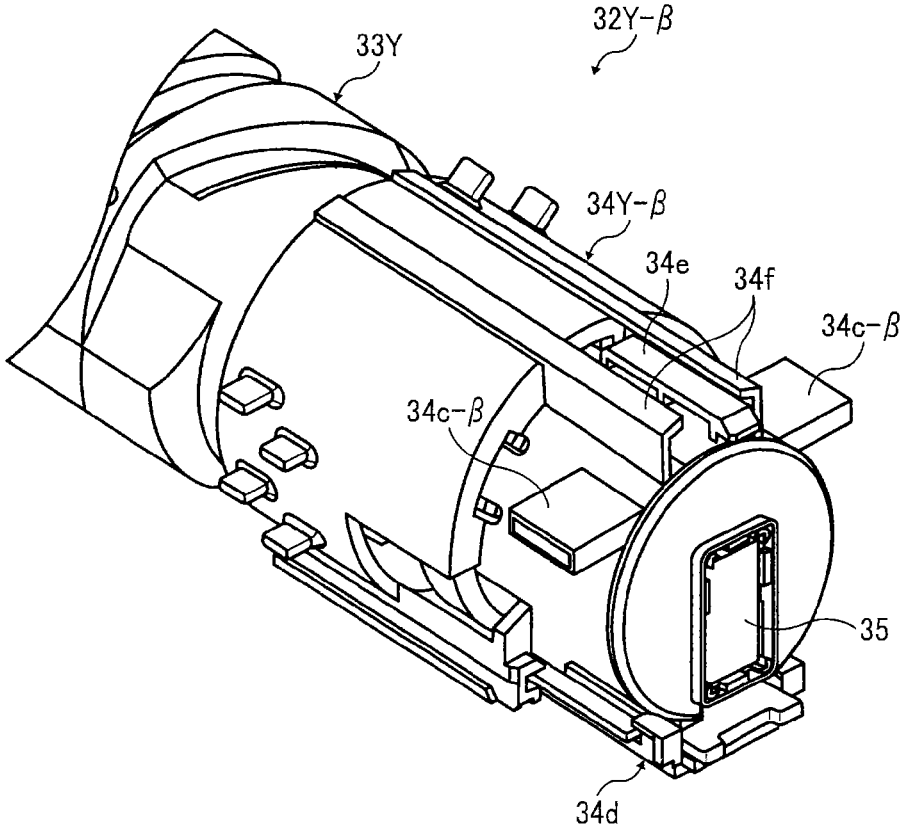


FIG. 53

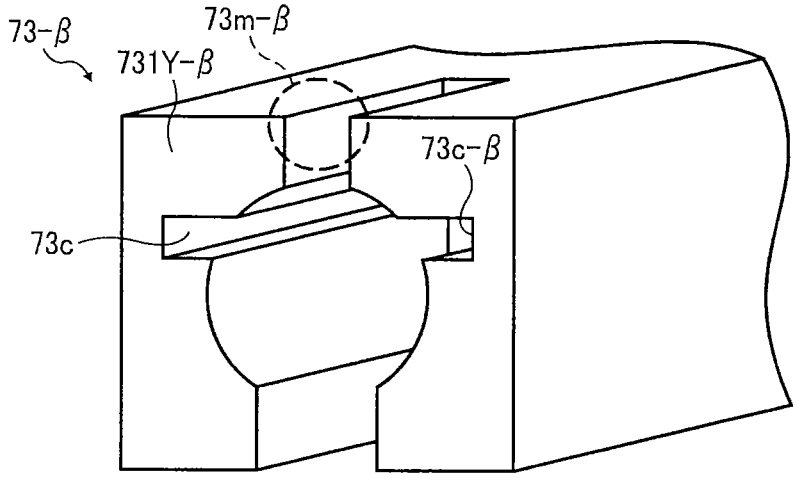


FIG. 54

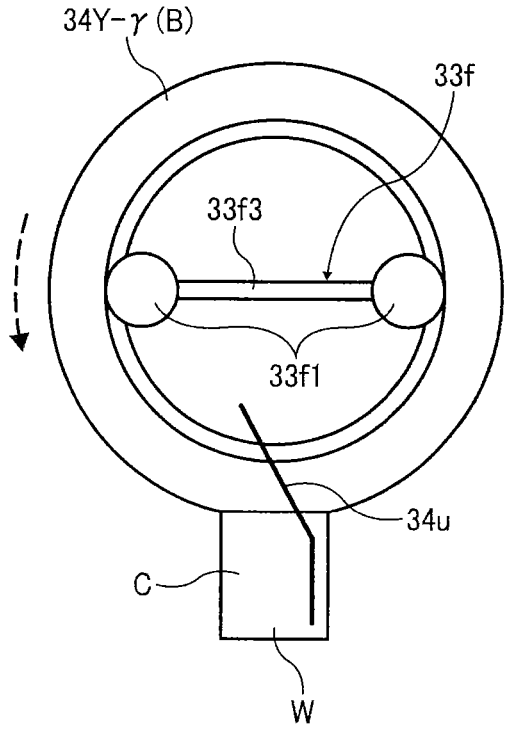


FIG. 55

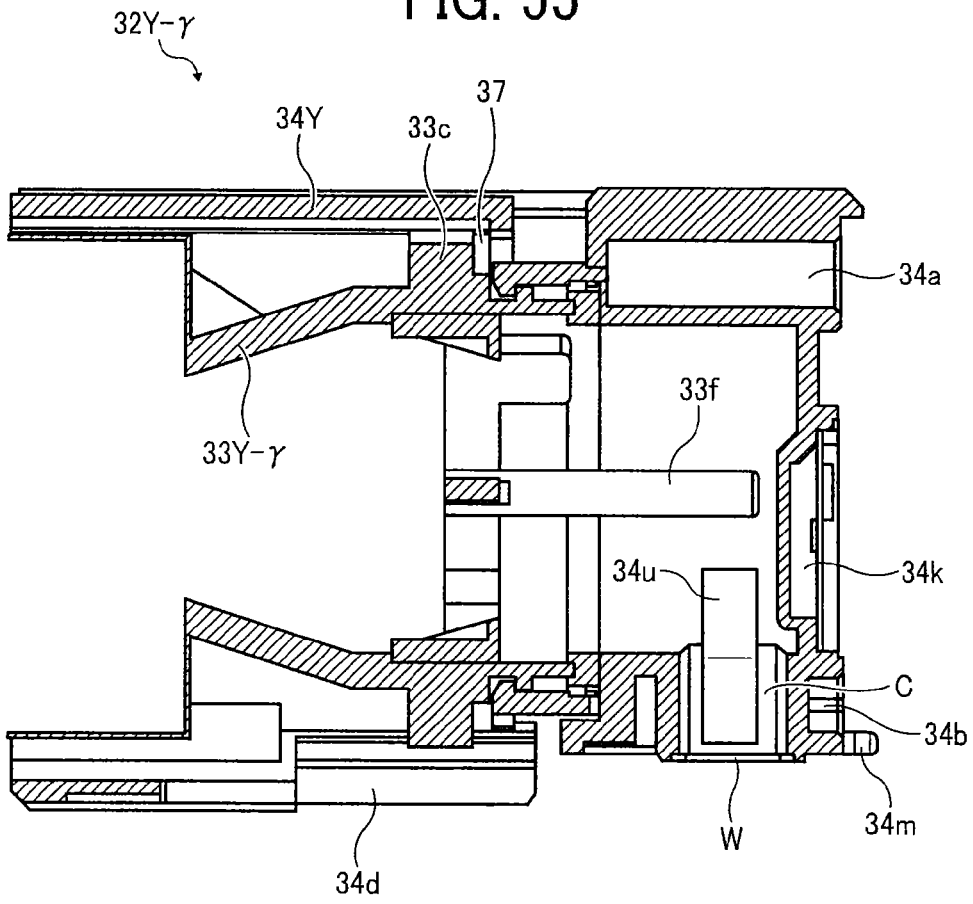

32Y-γ
34Y
33c
37
34a
33f
33Y-γ
34u
34k
C
34b
W
34m
34d

FIG. 56

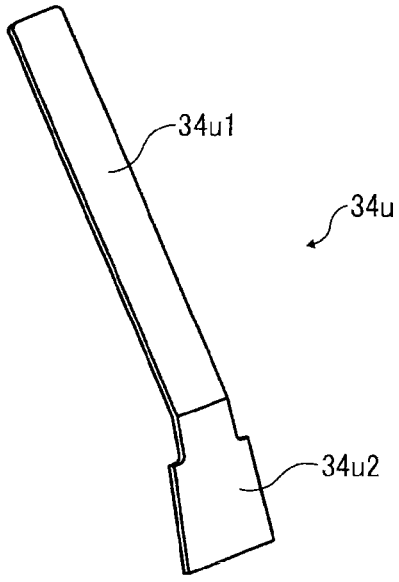
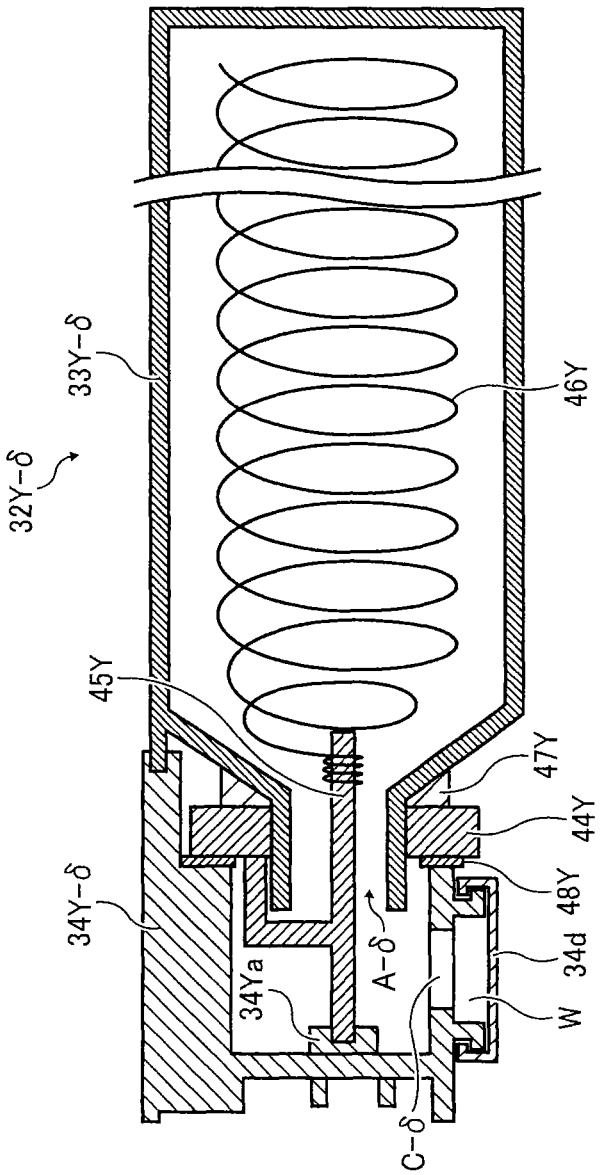

34u1
34u
34u2

FIG. 57



TONER CONTAINER, IMAGE FORMING APPARATUS INCLUDING SAME, AND CONNECTING STRUCTURE FOR CONNECTING TONER CONTAINER AND IMAGE FORMING APPARATUS

CROSS-REFERENCE TO RELATED APPLICATIONS

The present application is a continuation application of U.S. application Ser. No. 12/875,762, filed Sep. 3, 2010, which claims priority to Japanese Patent Application Nos. 2009-204358, filed on Sep. 4, 2009, and 2010-134544, filed on Jun. 11, 2010, and 2010-148907, filed on Jun. 30, 2010. The entire contents of the above-identified applications are incorporated herein by reference.

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a toner container included in an image forming apparatus such as a copier, a printer, a facsimile machine, a plotter, and a multi-function machine, and a connecting structure for connecting a toner container and an image forming apparatus.

2. Discussion of the Background

Electrophotographic image forming apparatuses such as copiers, printers, facsimile machines, plotters, multi-function machines, or the like typically include toner containers. In general, cylindrical toner containers (bottles) that are removably installable in the image forming apparatuses are used.

Thus, for example, in JP-H04-1681-A and JP2002-268344-A, a toner container (toner cartridge) that is removably installable in the image forming apparatus, and mainly includes a container body (bottle body) and a cap (handle member).

A problem with the arrangement shown in these examples occurs when a user inserts the toner container into the image forming apparatus with the container cap askew, resulting in positional deviation of the toner container relative to the image forming apparatus because the position of the container cap is not determined in the image forming apparatus.

In view of the foregoing, there is market demand for toner containers whose cap is reliably positioned in the image forming apparatus without adversely affecting discharge of the toner.

SUMMARY

In view of the foregoing, one illustrative embodiment of the present invention provides a toner container that is removably installable in an image forming apparatus and includes a cylindrical container body, a cap, and a shutter. The cylindrical container body, having an opening in one end thereof, conveys toner contained in the container body to the opening. The cap, into which the end of the container body having the opening is inserted, has a toner outlet to discharge the toner discharged from the opening of the container body vertically downward. The shutter, slidably held in a bottom portion of the cap, opens the toner outlet by movement from the cap side to the container body side when the toner container is installed in the image forming apparatus, and closes the toner outlet by movement from the container body side to the cap side when the toner container is removed from the image forming apparatus. The cap includes a primary positioning hole, a secondary positioning hole, and at least one first restriction member. The primary positioning hole, formed in a top front surface perpendicular to a longitudinal direction of the toner container, extends in the longitudinal direction and functions as a main positioning reference to determine an installation position of the cap relative to the image forming apparatus. The secondary positioning hole, formed in a bottom front surface perpendicular to the longitudinal direction of the toner container opposite the primary positioning hole, extends in the longitudinal direction forward the toner outlet and functions as a sub positioning reference to determine the installation position of the cap relative to the image forming apparatus. The first restriction member that positions the cap in a horizontal direction perpendicular to the longitudinal direction of the cap projects vertically upward from an outer circumferential surface of the cap and symmetrical about a virtual perpendicular line passing through a cross-sectional center position of the primary positioning hole in perpendicular to the long direction of the toner container.

Another illustrative embodiment of the present invention provides an image forming apparatus that includes a toner container frame, provided in a main body of the image forming apparatus, and at least one toner container, removably installable in the toner container frame. The toner container includes the cylindrical container body, the cap, and a shutter, slidably held on a bottom side of the cap, to open the toner outlet as the cap moves in the toner container frame in a direction in which the toner container is inserted into the toner container frame while the shutter is stopped in the toner container frame, and to close the toner outlet as the cap moves in the toner container frame in a direction in which the toner container is removed from the toner container frame while the shutter is stopped in the toner container frame. The toner container frame includes an insertion portion in which an inserting opening is formed to insert the toner container into the toner container frame, a container holder to hold the container body of the toner container, a cap holder to hold the cap of the toner container, provided in an extreme upstream portion of the toner container frame in a direction in which the toner container is inserted into the toner container frame. The cap holder includes a first reference pin, a second reference pin, and an engaged portion. The first reference pin, to engage the first hole of the cap of the toner container projects inward from an extreme upstream portion of an interior wall of the cap holder in the direction in which the toner container is inserted into the toner container frame. The second reference pin to engage the second hole of the cap of the toner container projects inward from extreme upstream interior wall of the cap holder in the direction in which the toner container is inserted into the toner container frame. The engaged portion, to engage the first restriction member of the cap of the toner container, projecting downward from a ceiling of the cap holder, extends in the direction in which the toner container is inserted into the toner container frame.

Another illustrative embodiment of the present invention provides a connecting structure for connecting a toner container and an image forming apparatus, including a shutter disposed on the toner container, and an engaging member that engages the shutter. The shutter is slidable between a first closed position covering a toner outlet formed in the container and a second opening position exposing the toner outlet upon installation of the toner container.

BRIEF DESCRIPTION OF THE DRAWINGS

A more complete appreciation of the disclosure and many of the attendant advantages thereof will be readily obtained as the same becomes better understood by reference to the fol-

lowing detailed description when considered in connection with the accompanying drawings, wherein:

FIG. **1** is an overall schematic view illustrating a configuration of an image forming apparatus according to a first illustrative embodiment of the present invention;

FIG. **2** is a schematic diagram illustrating an image forming unit included in the image forming apparatus shown in FIG. **1**;

FIG. **3** is a diagram schematically showing supply of toner to the toner supply device from the toner container connected to the toner supply device included in the image forming apparatus shown in FIG. **1**;

FIG. **4** is a perspective view of a toner container frame included in the image forming apparatus shown in FIG. **1**, in which the toner container shown in FIG. **3** is set;

FIG. **5** is a perspective view of the toner container shown in FIG. **3** when view from obliquely above;

FIG. **6** is a perspective view of the toner container shown in FIG. **5** when view from obliquely underneath;

FIG. **7** is a set of six sides views of the toner container shown in FIG. **5**, including a topside view, a front view, a left side view, a backside view, a bottom view, and a right side view;

FIG. **8** is a front view of the toner container shown in FIG. **5** when view from a cap side;

FIG. **9**A is an exploded view illustrating the toner container shown in FIG. **5**;

FIG. **9**B is an exploded view illustrating a variation of the toner container shown in FIG. **9**A;

FIG. **10** is a perspective view of a container body included in the toner container shown in FIG. **5** when view from obliquely above;

FIG. **11** is an enlarged view illustrating vicinity of an opening of the container body shown in FIG. **10**;

FIG. **12** is a perspective view illustrating an agitator provided in the container body shown in FIG. **11**;

FIG. **13** is a perspective view illustrating a variation of the agitator provided in the container body shown in FIG. **11**;

FIG. **14** is a perspective view illustrating a cap included in the toner container shown in FIG. **5** when viewed from the front side obliquely;

FIG. **15** is a perspective view illustrating the cap shown in FIG. **14** when viewed from another angle;

FIG. **16** is a perspective view illustrating the cap shown in FIG. **14** when viewed from connection side in which the cap connects the container body in the toner container;

FIG. **17** is a perspective view illustrating the cap shown in FIG. **14** when viewed from another angle of the connection side shown in FIG. **16**;

FIG. **18** is a perspective view illustrating a shutter provided on the cap shown in FIG. **14** when viewed from the bottom obliquely, when the shutter fully closes a toner outlet formed in a bottom surface of the cap;

FIG. **19** is a perspective view illustrating the shutter provided on the cap shown in FIG. **18**, when the shutter partly opens the toner outlet;

FIG. **20** is a perspective view illustrating the shutter provided on the cap shown in FIG. **18**, when the shutter fully opens the toner outlet;

FIGS. **21**A through **21**C are diagrams schematically showing a process in which the shutter is opened relative to a shutter container of the cap shown in FIG. **16** in synchronization with the installation of the toner container into the toner container frame;

FIG. **22** is a perspective view illustrating the cap when viewed from the angle shown in FIG. **15**, when the shutter is detached from the cap;

FIG. **23** is a perspective view illustrating a first cap body in the cap shown in FIG. **22**;

FIG. **24** is a perspective view illustrating the first cap body in the cap shown in FIG. **23** when viewed from another angle;

FIG. **25** is a perspective view illustrating a second cap body in the cap shown in FIG. **22**;

FIG. **26** is a perspective view illustrating the shutter shown in FIG. **18**;

FIG. **27** is a perspective view illustrating the shutter shown in FIG. **26**, when viewed from another angle;

FIG. **28**A is a cross-sectional view illustrating vicinity of the cap in the toner container shown in FIG. **9**A;

FIG. **28**B is a cross-sectional view illustrating a variation of the cap in the toner container shown in FIG. **9**B;

FIG. **29** is a perspective view illustrating an inner portion of the cap in the toner container shown in FIG. **5**;

FIGS. **30**A through **30**D show vicinity of inserting openings in inserting portions of the toner container frame shown in FIG. **4** when the respective color of the toner containers are set in the inserting opening;

FIGS. **31**A through **31**C shows variations of the inserting portions shown in FIGS. **30**A through **30**D when variations of the toner containers are set in the insertion openings of the insertion portions.

FIG. **32** is a perspective view illustrating a bottle holder in the toner container frame shown in FIG. **4**;

FIG. **33** is a top view illustrating the bottle holder in the toner container frame shown in FIG. **32**;

FIG. **34** is an enlarged perspective view illustrating the bottle holder close to front end shown in FIG. **32**;

FIG. **35** is an enlarged perspective view illustrating the bottle holder close to front end shown in FIG. **34** when viewed from another angle;

FIG. **36** is an enlarged perspective view illustrating the bottle holder close to front end shown in FIG. **34** when viewed from another angle;

FIG. **37** is a perspective view illustrating a cap holder in the toner container frame shown in FIG. **4**;

FIG. **38** is an enlarged perspective view illustrating vicinity of a front wall of the cap holder shown in FIG. **37**;

FIG. **39** is an enlarged perspective view illustrating the vicinity of the front wall of the cap holder shown in FIG. **38** when viewed from another angle;

FIG. **40** is an enlarged perspective view illustrating the vicinity of the front wall of the cap holder shown in FIG. **38** when viewed from another angle;

FIG. **41** is a cross sectional view illustrating the cap holder shown in FIG. **37**;

FIG. **42** is a perspective view illustrating a process in which each toner container is fitted into the toner container frame shown in FIG. **4**;

FIG. **43** is a bottom view illustrating a process in which the toner outlet shown in FIG. **20** is opened by the shutter of the cap by engaging the shutter with a shutter closing member in the cap holder;

FIGS. **44** and **45** are bottom views illustrating the process in which the toner outlet is further opened by the shutter of the cap by engaging the shutter with a shutter closing member in the cap holder shown in FIG. **43**;

FIGS. **46**A through **46**D are schematic diagrams illustrating a process in which the cap of the toner container shown in FIG. **14** is inserted into the cap holder shown in FIG. **37**;

FIG. **47** is a perspective diagram illustrating vicinity of the toner outlet shown in FIG. **20** in the cap placed upside down and a seal member of the cap holder;

FIGS. **48**A and **48**B are perspective diagrams illustrating variations of the vicinity of the toner outlet in the cap shown in FIG. **47** placed upside down and the seal member of the cap holder;

FIG. **49** is a perspective view illustrating a cap of a toner container according to a second illustrative embodiment of the present invention;

FIG. **50** is a front view illustrating the cap of the toner container shown in FIG. **49**;

FIG. **51** is a schematic perspective view illustrating a cap holder in which the cap shown in FIG. **49** is inserted;

FIG. **52** is a perspective view illustrating a cap of a toner container according to a third illustrative embodiment of the present invention;

FIG. **53** is a schematic perspective view illustrating a cap holder in which the cap shown in FIG. **52** is inserted;

FIG. **54** is a cross sectional view illustrating a toner container according to a fourth illustrative embodiment of the present invention, when viewed from front side;

FIG. **55** is a cross sectional view illustrating vicinity of a cap of the toner container shown in FIG. **54**;

FIG. **56** is a perspective view illustrating a flexible member provided close to a toner outlet in the cap of the toner container shown in FIG. **54**; and

FIG. **57** is a cross sectional view illustrating a structure of a toner container according to a fifth illustrative embodiment of the present invention, when viewed from longitudinal side of the toner container.

DETAILED DESCRIPTION OF PREFERRED EMBODIMENTS

In describing preferred embodiments illustrated in the drawings, specific terminology is employed for the sake of clarity. However, the disclosure of this patent specification is not intended to be limited to the specific terminology so selected and it is to be understood that each specific element includes all technical equivalents that operate in a similar manner and achieve a similar result.

Referring now to the drawings, wherein like reference numerals designate identical or corresponding parts throughout the several views thereof, and particularly to FIG. **1**, an image forming apparatus that is an electrophotographic printer (hereinafter referred to as a printer) according to an illustrative embodiment of the present invention is described. It is to be noted that although the image forming apparatus of the present embodiment is a printer, the image forming apparatus of the present invention is not limited to a printer.

First Embodiment

Referring now to FIGS. **1** through **46**, a first embodiment of the present invention is described in detail below.

Initially, structure and operation of the image forming apparatus according to the present embodiment are described. FIG. **1** is a schematic diagram showing a structure of an entire image forming apparatus **100** according to the first embodiment of the present invention. As shown in FIG. **1**, in a toner container frame **70** is provided in an upper part of the image forming apparatus **100**, and four toner containers **32**Y, **32**M, **32**C, and **32**K respectively corresponding to yellow, magenta, cyan, and black are detachably installable in the toner container frame **70** (see FIGS. **4** and **42**). The toner container **32**Y functions as a toner container.

An intermediate transfer unit **15** is provided beneath the toner container frame **70**. The intermediate transfer unit **15** includes an intermediate transfer belt **8**. Image forming units **6**Y, **6**M, **6**C, and **6**K respectively corresponding to yellow, magenta, cyan, and black are positioned to face the intermediate transfer belt **8**. Toner supply devices **60**Y, **60**M, **60**C, and **60**K are provided beneath the corresponding toner containers **32**Y, **32**M, **32**C, and **32**K. Different color toner contained in the toner containers **32**Y, **32**M, **32**C, and **32**K are supplied to corresponding developing devices in the image forming units **6**Y, **6**M, **6**C, and **6**K by the corresponding toner supply devices **60**Y, **60**M, **60**C, and **60**K.

The image forming units **6**Y, **6**M, **6**C, and **6**K are described in further detail below with reference to FIG. **2** in addition to FIG. **1**, after which the elements shown in FIG. **1** that are not described above are described. In the following description, since configurations of elements for forming yellow, magenta, cyan, and black images are substantially identical to each other, in some cases, elements for yellow (given the reference character suffix Y) are described as representative.

FIG. **2** is a schematic diagram illustrating the image forming unit **6**Y included in the image forming apparatus shown in FIG. **1**.

As shown in FIG. **2**, the image forming unit **6**Y corresponding to yellow includes a photoconductor drum **1**Y, and in the vicinity of the photoconductor drum **1**Y, a charging device **4**Y, a developing device **5**Y (developing section), a cleaning device **2**Y, and a discharging device (not shown) are provided in the image forming unit **6**Y. Image forming processes (a charging process, an exposing process, a developing process, a primary-transfer process, and a cleaning process) are performed on the photoconductor drum **1**Y, and a yellow image is formed on the photoconductor drum **1**Y.

Each of the image forming units **6**M, **6**C, and **6**K has a structure substantially identical to the structure of the image forming unit **6**Y and forms a corresponding color image. Therefore, in the following, the image forming unit **6**Y is mainly described while omitting the descriptions of the image forming units **6**M, **6**C, and **6**K.

In FIG. **2**, the photoconductor drum **1**Y is rotated in a clockwise direction indicated by arrow c, by a driving motor (not shown). Then, the surface of the photoconductor drum **1**Y is uniformly charged by the charging device **4**Y (the charging process), after which the surface of the photoconductor drum **1**Y reaches a portion receiving a laser beam L emitted from an exposure device **7** (see FIG. **1**) and an electrostatic latent image corresponding to yellow is formed on the photoconductor drum **1**Y with the laser beam L at that position (the exposing process).

Then, the surface of the photoconductor drum **1**Y on which the electrostatic latent image has been formed reaches a position facing the developing device **5**Y, and the electrostatic latent image is developed at the position. Thus, a yellow toner image is formed (the developing process).

Then, the surface of the photoconductor drum **1**Y on which the toner image has been formed reaches a position facing the intermediate transfer belt **8** and a primary-transfer bias roller **9**Y, and the toner image on the photoconductor drum **1**Y is transferred onto the intermediate transfer belt **8** at that position (the primary-transfer process). At this time, a small amount of toner that has not been transferred onto the intermediate transfer belt **8** remains on the photoconductor drum **1**Y.

Subsequently, the surface of the photoconductor drum **1**Y reaches a position facing the cleaning device **2**Y and the toner remaining on the surface of the photoconductor drum **1**Y is mechanically removed by a cleaning blade **2***a* (the cleaning process).

Finally, the surface of the photoconductor drum **1**Y reaches a position facing the discharging device and electric charges remaining on the surface of the photoconductor drum **1**Y are discharged.

Thus, the image forming process on the photoconductor drum **1**Y is completed.

It is to be noted that the above-described image forming process is performed in the image forming units **6**M, **6**C, and **6**K, similar to the image forming unit **6**Y. That is, the corresponding photoconductor drums **1**M, **1**C, and **1**K are irradiated with the laser beams L corresponding to image data, emitted from the exposure device **7** positioned beneath the image forming units **6**M, **6**C, and **6**K. Specifically, the exposure device **7** causes light sources to emit the laser beams L and directs the laser beams L onto the corresponding photoconductor drums **1**M, **1**C, and **1**K via plural optical elements while the laser beams L are deflected by a rotating polygon mirror to scan the surfaces of the photoconductor drums **1**M, **1**C, and **1**K, respectively. After the developing process, the toner images formed on the respective photoconductor drums **1**Y, **1**M, **1**C, and **1**K are transferred onto the intermediate transfer belt **8** and superimposed one on another thereon. Undergoing theses processes, a multicolor image is formed on the intermediate transfer belt **8**.

Returning now to FIG. **1**, the intermediate transfer unit **15** includes the intermediate transfer belt **8**, four primary-transfer bias rollers **9**Y, **9**M, **9**C, and **9**K, a secondary-transfer backup roller **12**, plural tension rollers (not shown), and an intermediate transfer cleaning section (not shown). The intermediate transfer belt **8** is supported by plural rollers and is endlessly rotated in a direction indicated by arrow T shown in FIG. **1** by the secondary-transfer backup roller **12**.

The four primary-transfer bias rollers **9**Y, **9**M, **9**C, and **9**K respectively press against the four photoconductor drums **1**Y, **1**M, **1**C, and **1**K via the intermediate transfer belt **8**, thus forming primary-transfer nips therebetween. A transfer bias voltage whose polarity is inverted relative to the polarity of the toner is applied to the four primary-transfer bias rollers **9**Y, **9**M, **9**C, and **9**K. The intermediate transfer belt **8** sequentially passes through the primary-transfer nips formed between the primary-transfer bias rollers **9**Y, **9**M, **9**C, and **9**K and the photoconductor drums **1**Y, **1**M, **1**C, and **1**K while rotating in the direction indicated by arrow T shown in FIG. **1**. Thus, the toner images on the photoconductor drums **1**Y, **1**M, **1**C, and **1**K are primarily transferred onto the intermediate transfer belt **8** and superimposed one on another thereon, forming a four-color (multicolor) toner image.

Then, the intermediate transfer belt **8** onto which the toner images have been transferred and superimposed one on another thereon reaches a position facing a secondary-transfer roller **19**. A secondary-transfer nip is formed at the position where the intermediate transfer belt **8** is sandwiched between the secondary-transfer backup roller **12** and the secondary-transfer roller **19**. Then, the four-color toner image formed on the intermediate transfer belt **8** is transferred onto a recording medium P (for example, paper) carried to the secondary nip (a secondary transfer process). At this time, a certain amount of toner can remain on the intermediate transfer belt **8**, not transferred onto the recording medium P.

Then, the intermediate transfer belt **8** reaches a position facing the intermediate transfer cleaning section and the toner remaining on the intermediate transfer belt **8** is removed at that position. Thus, the secondary-transfer process that is performed on the intermediate transfer belt **8** is completed.

The recording medium P is carried to the secondary nip from a paper feeding section **26** positioned at a lower part of the image forming apparatus **100** via a paper feeding roller **27**, a pair of registration rollers **28**, and so on.

Specifically, the plural recording media P (multiple sheets of paper) are stacked and stored in the paper feeding section **26**. When the paper feeding roller **27** is rotated counterclockwise in FIG. **1**, the recording medium P on the top is carried to a position between the pair of registration rollers **28**.

The recording medium P carried to the pair of registration rollers **28** is temporarily stopped at a roller nip position of the pair of registration rollers **28** whose rotation is stopped. Then, the pair of registration rollers **28** is rotated again, timed to coincide with formation of the multicolor image on the intermediate transfer belt **8**, and thus the recording medium P is carried to the secondary-transfer nip. Then, the multicolor image is transferred onto the recording medium P.

The recording medium P onto which the multicolor image has been transferred in the secondary-transfer nip is carried to a fixing section **20** and the multicolor image on the recording medium P is fixed with heat and pressure from a fixing belt (not shown) and a pressure roller (not shown) of the fixing section **20**.

The recording medium P on which the multicolor image has been formed is output to a stack section **30** via a pair of paper output rollers **29**. When plural recording media P are output, the output plural recording media P are sequentially stacked on the stack section **30**. Thus, a sequence of image forming processes performed in the image forming apparatus **100** is completed.

Next, with reference to FIG. **2**, structure and operation of the developing device **5**Y in the image forming unit **6**Y are described in detail below.

The developing device **5**Y includes a developing roller **51**Y facing the photoconductor drum **1**Y, a doctor blade **52**Y facing the developing roller **51**Y, developer containers **53**Y and **54**Y, two developer conveying screws **55**Y respectively disposed in the developer containers **53**Y and **54**Y, and a concentration detector **56**Y for detecting a toner concentration in a developer G. The developing roller **51**Y includes a magnet (not shown) fixed inside the developing roller **51**Y and a sleeve (not shown) that is outermost portion of the developing roller **51** and is rotated around the magnet. The developer G that is two-component developer consisting essentially of carrier particles (toner carrier) and toner particles is contained in the developer containers **53**Y and **54**Y. The developer container **54**Y is connected to a toner dropping route **64**Y via an opening formed on an upper side of the developer container **54**Y.

Next, operation of the developing device **5**Y is described below.

The sleeve of the developing roller **51**Y is rotated in a direction indicated by arrow b shown in FIG. **2**, and the developer G carried on the developing roller **51**Y by a magnetic field generated by the magnet is transported in that direction as the sleeve is rotated. The toner concentration of the developer G in the developing device **5**Y is adjusted within a predetermined range. Specifically, toner contained in the toner container **32**Y (see FIG. **1**) is supplied to the developer container **54**Y by the toner supply device **60**Y (see FIG. **1**) corresponding to the amount of toner consumed in the developing device **5**Y. The toner supply device **60**Y is described below in detail.

The toner supplied to the developer container **54**Y are mixed with the developer G in the developer container **54**Y, and the developer G is circulated in the two developer containers **53**Y and **54**Y while stirred by the developer conveying screws **55**Y. While the developer G is moved in the direction perpendicular to the plane of the paper on which FIG. **2** is

drawn, the toner particles in the developer G adhere to carrier particles, charged with friction with the carrier particles, and are carried on the developing roller **51**Y together with the carrier particles by a magnetic force formed on the developing roller **51**Y.

Then, the developer G carried on the developing roller **51**Y is transported in the direction indicated by arrow b in FIG. **2** to the doctor blade **52**Y. The amount of the developer G on the developing roller **51**Y is adjusted to a suitable value by the doctor blade **52**Y, after which the developer G is carried to a developing region facing the photoconductor drum **1**Y. The toner particles in the developer G are attracted to an electrostatic latent image formed on the photoconductor drum **1**Y by an electric field generated in the developing region. As the sleeve rotates, the developer G remaining on the developing roller **51**Y reaches an upper part in the developer container **53**Y and drops from the developing roller **51**Y.

Next, referring to FIGS. **3** and **4**, the toner supply devices **60**Y, **60**M, **60**C, and **60**K are described below.

Herein, FIG. **3** is a diagram schematically showing supply of toner to the toner supply device **60** from the toner container **32**Y connected to the toner supply device **60**. FIG. **4** is a perspective view of the toner container frame **70** included in the image forming apparatus **100** shown in FIG. **1**, respectively. In FIGS. **3** and **4**, the respective color toners contained in the corresponding toner containers **32**Y, **32**M, **32**C, and **32**K in the toner container frame **70** are suitably supplied to the corresponding developing devices **5**Y, **5**M, **5**C, and **5**K by the corresponding toner supply devices **60**Y, **60**M, **60**C, and **60**K according to the amount of the corresponding toner consumed. The structure of each of the toner supply devices **60**Y, **60**M, **60**C, and **60**K is substantially equal, and the structure of each of the toner containers **32**Y, **32**M, **32**C, and **32**K is substantially equal. Therefore, the toner supply device **60**Y and the toner container **32**Y are described as representative.

When the toner container **32**Y is installed in the toner container frame **70** in a direction indicated by arrow Q in FIG. **4**, a shutter **34***d* (shown in FIGS. **3** and **9**) of the toner container **32**Y is moved in synchronization with the installation of the toner container **32**Y, and a toner outlet W (see FIG. **3**) of the toner container **32**Y is opened. Consequently, the toner outlet W of the toner container **32**Y overlaps a toner supply opening **73***w* of the toner supply device **60**. Accordingly, the toner contained in the toner container **32**Y is discharged from the toner container **32**Y through the toner outlet W and the toner supply opening **73***w* and stored in a toner tank of the toner supply device **60**Y.

As shown in FIG. **3**, the toner container **32**Y is a substantially cylindrical toner bottle and includes a container body (bottle body) **33**Y formed integrally with a gear **33**Yc (**33***c*) and a cap **34**Y. The cap **34**Y is attached to the toner container frame **70** so as not to rotate. The toner outlet W is formed on a lower side of the cap **34**Y of the toner container **32**Y. In addition, the toner supply device **60**Y includes a toner tank **61**Y, a toner conveying screw **62**Y, a toner conveying tube **63**Y, the toner dropping route **64**Y (shown in FIG. **2**), a toner agitator **65**Y, a toner end sensor **66**Y (detecting unit), and a driving unit **91**. It is to be noted that, in FIG. **3**, reference character **33***d* represents a handle part.

In FIG. **3**, the container body **33**Y is rotatably held by the cap **34**Y and is rotated in a direction indicated by arrow d shown in FIG. **3** by the driving unit **91** that includes a driving motor (not shown), a driving gear **81**, and the like. By rotating the container body **33**Y, spiral protrusions **33***b* protruding inward from an inner circumferential face of the container body **33**Y convey the toner contained in the container body **33**Y in a longitudinal direction of the toner container **32**Y (from left to right in FIG. **3**) and discharges the toner from the toner outlet W.

That is, the container body **33**Y of the toner container **32**Y is rotated by the driving unit **91** as required, thus supplying the toner suitably to the toner tank **61**Y of the toner supply device **60**. When the service life of each of the toner containers **32**Y, **32**M, **32**C, and **32**K has expired, that is, when almost all toner in the toner container **32**Y have been consumed, an old one is replaced with a new one.

Further, the toner tank **61**Y is positioned beneath the toner outlet W of the container body **33**Y of the toner container **32**Y and stores the toner discharged through the toner outlet W from the toner container **32**Y via the toner supply opening **73***w* (see FIGS. **3** and **42**). The bottom part of the toner tank **61**Y is connected to an upstream side in the developer conveyance direction of the toner conveying screw **62**Y.

The toner end sensor **66**Y is disposed on a wall surface of the toner tank **61**Y at a predetermined height from the bottom surface of the toner tank **61**Y. The toner end sensor **66**Y detects that the amount of the toner stored in the toner tank **61**Y becomes less than a predetermined amount. As the toner end sensor **66**Y, a piezoelectric sensor can be used.

With reference to FIG. **3**, when the toner end sensor **66**Y detects a signal indicating that the amount of the toner stored in the toner tank **61**Y is less than the predetermined value, the signal is sent to a controller **90**. The controller **90** controls the driving unit **91** (including the driving gear **81**) to rotate the toner container **32**Y for a predetermined period to supply toner to the toner tank **61**Y.

When the toner end sensor **66**Y continues to detect the signal even if the driving unit **91** repeats rotating the toner conveyance member **32**Y**3** in the toner container **32**Y during a predetermined time period, the controller **90** determines that no toner remains in the toner container **32**Y. Then, the controller **90** displays a message that instructs users to replace the toner container **32**Y with a new one on a display (not shown) of the image forming apparatus **100**.

The toner agitator **65**Y (rotating member) is disposed at an inner center position of the toner tank **61**Y near the toner end sensor **66**Y for preventing the toner stored in the toner tank **61**Y from being coagulated. The toner agitator **65**Y includes a flexible member (not shown) provided on a shaft, rotates in a clockwise direction indicated by an arrow shown in FIG. **3**, and stirs the toner in the toner tank **61**Y. In addition, since the tip of the flexible member of the toner agitator **65**Y slidably contacts the detecting surface of the toner end sensor **66**Y with every a rotational cycle of the toner agitator **65**Y, a decrease in the detecting accuracy due to toner adhering to the detecting surface of the toner end sensor **66**Y is prevented.

The toner conveying screw **62**Y conveys the toner retained in the toner tank **61**Y obliquely upward. More specifically, the toner conveying screw **62**Y linearly conveys the toner from the bottom side of the toner tank **61**Y to the upper side of the developing device **5**Y. Then, the toner thus conveyed by the toner conveying screw **62**Y drops under its own weight through the toner dropping route **64**Y (see FIG. **2**) and is supplied to the development device **5**Y (developer container **54**Y).

Referring now to FIG. **4**, the toner container frame **70** includes a cap holder **73** that holds four caps **34**Y, **34**M, **34**C, and **34**K of the toner container **32**Y, **32**M, **32**C, and **32**K, a bottle holder **72** that holds four container bodies **33**Y, **33**M, **33**C, **33**K of the toner containers (bottles) **32**Y, **32**M, **32**C, and **32**K, and an inserting portion **71** having four inserting openings **710** through which the toner containers **32**Y, **32**M, **32**C, and **32**K are inserted when the toner containers **32**Y,

32M, 32C, and 32K are inserted into and detached from the toner container frame 70. The structure of the bottle holder 72 and the inserting portion 71 is described in detail below with reference to FIGS. 32 through 46.

As shown in FIG. 1, when a main body cover (not shown) positioned on the front side of the image forming apparatus 100 is opened, the inserting portion 71 of the toner container frame 70 is exposed. That is, attachment and removal of the toner containers 32Y, 32M, 32C, and 32K are performed from the front side of the image forming apparatus 100 in the longitudinal direction of the toner containers 32Y, 32M, 32C, and 32K, that is, a direction orthogonal to the surface of paper on which FIG. 1 is drawn.

Herein, the length in the longitudinal direction of the bottle holder 72 is almost equal to the length in the longitudinal direction of the container body 33Y. In addition, the cap holder 73 is attached to one side (front end side) of the bottle holder 72 in the longitudinal direction (direction of insertion), and the inserting portion 71 is provided on the other side (back end side) of the bottle holder 72 in the longitudinal direction (direction of insertion).

Therefore, as the toner container 32Y is inserted into the toner container frame 70, the cap 34Y passes through the bottle holder 72, slides on the bottle holder 72 for a certain distance, and then is set in the cap holder 73.

Further, four antennas 73*e* (see FIGS. 38 and 39) dedicated for radio frequency identification (RFID) chips 35 (see FIGS. 5 and 9) are provided on the cap holder 73 of the toner container frame 70. Specifically, the four antennas 73*e* communicate with the RFID chips 35, serving as electronic data storages, installed in respective mounting sections 34*k* (see FIGS. 14 and 15) positioned on a front surfaces of the corresponding toner containers 32Y, 32M, 32C in a direction in which the toner container 32Y is installed into the toner container holder 70. The toner container 32Y, 32M, 32C, and 32K are aligned on the antenna 73*e* so that the RFID chips 35 face the antennas 73*e*, respectively.

The data exchanged between the toner container 32Y, 32M, 32C, and 32K and the image forming apparatus 100 includes, for example, the production serial number of the toner container, the recycle number of the toner container, the type of toner, the production lot number of the toner, the production date of the toner, the manufacturer of the toner, the amount of toner in the toner container, the multicolor of toner, and a usage history of the image forming apparatus 100. Other data may also be included.

Alternatively, after the toner container 32Y is set in the toner container frame 70 in the image forming apparatus 100, the data transmitted from the image forming apparatus 100 to the toner container 32Y is stored in the RFID chip 35.

Referring to FIGS. 5 through 31, configuration and operation of the toner container 32Y are described below.

It is to be noted that, in the toner container 32 and the toner container frame 70, reference character suffixes Y, M, C, and K attached to identical reference numerals indicate only that components indicated thereby are used for forming different single-color images, respectively, and hereinafter may be omitted when color discrimination is not necessary.

FIGS. 5 and 6 are perspective views of the toner container 32Y, and FIG. 7 is a set of six side views including a topside view, a front view, a left side view, a backside view, a bottom view, and a right side view. It is to be noted that reference character 34*f* in FIG. 7 represents second engaging members.

As shown in FIGS. 5 and 6, the toner container 32Y includes the container body 33Y and the cap 34Y. More specifically, with reference to FIG. 9A, which is an exploded view illustrating the toner container 32Y, the toner container 32Y includes an agitator 33*f*, a cap seal 37, the shutter 34*d*, a shutter seal 36 serving as a seal member, and the RFID chip 35 serving as the electronic data storage, in addition to the container body 33Y and the cap 34Y.

FIGS. 8, 9A, and 10 are respectively a front view (from the cap side), an exploded view, and a perspective view of the toner container 32Y, and FIG. 11 is an enlarged view illustrating vicinity of the opening A of the container body 33Y. It is to be noted that, in FIG. 8, reference characters 34*a*, 34*b*, 34*c*, 34*g*, 34*h*, 34*m*, 34*s* respectively represent a primary positioning hole, a secondary positioning hole, lateral protrusions, a first discrimination portion, a second discrimination portion, a projecting member, and a vertical faces.

As shown in FIGS. 9A through 11, an opening A and the gear 33*c* that rotates together with the container body 33Y are provided on the front end side of the container body 33Y (front side of paper on which FIG. 8 is drawn). An end portion of the bottle body 33Y that encloses the opening A is hereinafter referred to as a mouth portion 33*a* of the container body 33Y. In addition, a hollow B and a dropping route C are formed in the cap 34Y (see FIGS. 28A and 52). The opening A is formed in edge face 34*a* (backside end) of the container body 33Y so that the toner in the container body 33Y is discharged to a space (the hollow B) in the cap 34Y.

It is to be noted that, conveyance of toner from the container body 33Y to the hollow B in the cap 34Y (rotation of the toner container 33Y) is performed as required to an extent that the level of toner does not fall below a predetermined limitation line.

As shown in FIG. 11, the gear 33*c* rotates the container body 33Y around a rotary axis (indicated by a broken line in FIG. 11) by engaging the driving gear 81 in the toner container frame 70 of the image forming apparatus 100. More specifically, the gear 33*c* is provided around the opening A and has multiple teeth that are radially arranged relative to the rotary axis of the container body 33Y. In addition, the gear 33*c* is partly exposed from a notch 34*x* (shown in FIG. 22) at the lower left in FIG. 8 (an engagement position) and engages the driving gear 81 in the image forming apparatus 100. Then, the driving force transmitted from the driving gear 81 to the gear 33*c* rotates the container body 33Y in a clockwise direction in FIG. 8. It is to be noted that, in the present embodiment, the driving gear 81 and the gear 33*c* are spur wheel gears.

As shown in FIGS. 5 and 6, the handle part 33*d* that is grasped by the user when the toner container 32Y is inserted into and released from the image forming apparatus 100 is provided on the back end side of the container body 33Y opposite to the front end side where the gear 33*c* is positioned. The user inserts/releases the toner container 32Y into/from the image forming apparatus 100 while holding the handle part 33*d*. At this time, the toner container 32Y is moved in a direction indicated by arrow Q shown in FIG. 5.

Further, the spiral protrusions 33*b* are provided on the inner circumferential face of the container body 33Y. The spiral protrusions 33*b* are spiral grooves in the outer circumferential surface of the container body 33Y when viewed from outside. The spiral protrusions 33*b* are for discharging the toner in the container body 33Y to the opening A by rotating the container body 33Y in a predetermined direction. The container body 33Y is formed together with peripheral elements including the spiral protrusions 33*b*, the gear 33*c*, and the handle part 33*d*, provided on the container body 33Y, by blow molding.

With reference to FIGS. 9A through 11, in the toner container 32Y, the agitator 33*f* that rotates together with the container body 33Y is fitted in the mouth portion 33*a* of the bottle body 33Y that encloses the opening A. The agitator 33*f* including stick members extending from the opening edge of

the container body **33**Y to the hollow B in the cap **34**Y (see FIG. **28**A). The agitator **33***f* is rotated together with the opening A of the container body **33**Y, and therefore, workability in discharging toner from the opening A can be enhanced.

More specifically, as shown in FIG. **12**, the agitator **33***f* includes a pair of stick members **33***f***1**, a circular engagement edge **33***f***2**, and a bridge member **33***f***3**. The pair of stick member **33***f***1** protrudes from the circular engagement edge **33***f***2** to the hollow B in the cap **34**Y and their phases are shifted 180 degrees from each other. The bridge member **33***f***3** connects together the two stick members **33***f***1**. This agitator **33***f* is fitted into the opening A of the bottle body **33**Y, and the two cylindrical stick members **33***f***1** soften the toner in the hollow B formed in the cap **34**Y while suitably weakening the conveyance force to convey the toner from the opening A of the container body **33**Y to the hollow B in the cap **34**Y. As a result, the amount of the toner supplied from the opening A of the container body **33**Y to the hollow B in the cap **34**Y does not become excessive, and therefore, the possibility of clogging of the hollow B in the cap **34**Y with toner can be reduced. It is to be noted that, if the stick members **33***f***1** are disposed far from the toner outlet W and the toner dropping route C, the stick members **33***f***1** cannot soften the toner located closed to the toner outlet W because the two stick members **33***f***1** are cylindrical. Therefore, as shown in FIG. **28**A, the stick members **33***f***1** are extended to a position just above the toner outlet W (toner dropping route C). More specifically, end portions of the stick members **33***f***1** is extended in the lateral direction in FIG. **28**A more than half the diameter of the toner outlet W in that direction that is, their tips are positioned beyond a half line Ch (centerline of the cylindrical toner dropping route C) shown in FIG. **28**A).

In addition, when the amount of the toner supplied from the toner container **32**Y to the toner supply device **60**Y is relatively small because the amount of the toner consumed in the development device **5**Y is relatively small, the container body **33**Y of the toner container **32**Y rotates for only a short time, and accordingly the container body **32**Y rotates only a small angle to an extent that the container body **32**Y does not go into 360-degree roll. However, in this case, because the phases of the two stick members **33***f* are shifted by 180 degrees, one of the stick members **33***f***1** can soften the toner positioned close to the toner outlet W (toner dropping route C). Further, in the agitator **33***f* according to the present embodiment, the bridge member **33***f***3** is provided to cross a center position of the circular engagement edge **33***f***2**, the toner positioned close to the opening A can be softened by the bridge member **33***f***3**.

It is to be noted that, although the agitator **33***f* includes two stick members **33***f***1** in the present embodiment shown in FIG. **12**, alternatively the agitator **33***f* can include only a single stick member **33***f***1** as shown in FIG. **13**, or the agitator **33***f* can include three or greater number of stick members **33***f***1**.

(Variation)

It is to be noted that the shape of the agitation member **33***f* is not limited the above-described configuration. For example, as shown in FIGS. **9**B and **28**B, the toner container **32**Y can adopt an agitation member **32***f-a* that includes a pair of stick members **33***f***1**-*a* instead of the stick members **33***f***1** shown in FIG. **12** as well. The pair of stick members **33***f***1**-*a* protrudes from the circular engagement edge **33***f***2** to the hollow B in the cap **34**Y and also protrudes inward of the small diameter space D of the container body **33**Y from the circular engagement edge **33***f***2**, and their phases are shifted 180 degrees from each other. In this variation, the stick members **33***f***1**-*a* of the agitation ember **33***f-a* can soften the toner in the small diameter space D of the container body **33**Y in addition to the toner in the hollow B.

In this variation, similarly to the agitation member **33***f*, the two cylindrical stick members **33***f***1**-*a* soften the toner in the hollow B while suitably weakening the conveyance force to convey the toner from the opening A of the container body **33**Y to the hollow B in the cap **34**Y, and, because the stick members **33***f***1** are extended to a position just above the toner outlet, the stick member **33***f***1** can soften the toner located close to the toner outlet W. In addition, when the amount of the toner supplied from the toner container **32**Y to the toner supply device **60**Y is relatively small because the amount of the toner consumed in the development device **5**Y is relatively small, the container body **33**Y of the toner container **32**Y rotates for only a short time, and accordingly the container body **32**Y rotates only a small angle to an extent that the container body **32**Y does not go into 360-degree roll. However, in this case, because the phase of the two stick members **33***f* are shifted by 180 degrees, one of the stick members **33***f***1** can soften the toner positioned close to the toner outlet W (toner dropping route C). Further, the agitation member **33***f***-1** also includes the bridge member **33***f***3** provided to cross a center position of the circular engagement edge **33***f***2**, and therefore, the toner positioned close to the opening A can be softened by the bridge member **33***f***3**.

Although the agitator **33***f-a* includes two stick members **33***f***1**-*a* in the present variation, alternatively the agitator **33***f-a* can include only a single stick member **33***f***1**-*a*, or the agitator **33***f-a* can include three or greater number of stick members **33***f***1**-*a*.

Additionally, with reference to FIGS. **9**A and **10**, a protrusion **33***e* (hereinafter also "an engagement portion **33***e*") is provided an entire outer circumferential surface of the mouth portion **33***a* of the container body **33**Y and engages an inside hook **34***j* (see FIG. **29**) so that the container body **33**Y and the cap **34**Y are connected together. Thus, the container body **33**Y engages the cap **34**Y rotatably relative to the cap **34**Y. Therefore, the gear **33***c* rotates relative to the cap **34**Y.

Further, referring to FIG. **28**A, the container body **33**Y includes a small-diameter space F positioned close to the gear **33***c* (front end side of the toner container) has an internal diameter A**1** smaller than an internal diameter D**1** of a containing space D of the container body **33**Y in which the spiral protrusions **33***b* are formed.

A pump-up space E (indicated by a broken line circle shown in FIGS. **9**A, **10** and see FIG. **28**A) projecting inward from the internal face of the container body **33**Y is provided close to the small-diameter space F on the front end side of the container body **33**Y. When the toner is conveyed to the opening A by the spiral protrusions **33***b* as the container body **33**Y rotates, the toner is pumped up to the small-diameter space F on the front end side of the container body **33**Y through the pump-up space E. Then, the toner pumped up to the small-diameter space F is agitated by the agitator **33***f* and is discharged from the opening A to the hollow B in the cap **34**Y.

Turning now to FIGS. **14** through **17**, structure and operation of the cap **34**Y according to the present embodiment are described below.

The toner container **32**Y includes the shutter **34***d*, the shutter seal **36** serving as a seal member, the cap seal **37**, and the RFID chip **35** (electronic data storage) as described above. The mouth portion **33***a* enclosing the opening A of the container body **33**Y is inserted into back end side of an insertion opening **34***z* (see FIG. **29**) of the cap **34**Y, whose interior diameter is larger than that of the hollow B. With reference to FIGS. **20** and **28**, the toner outlet W is formed in the lowest portion on the back end side of the cap **34**Y so that the toner discharged from the opening A is discharged outside by dropping under its own weight.

In addition, the shutter **34***d* to open and close the toner outlet W is slidably held on the back end side of the cap **34**Y. More specifically, the toner outlet W is opened by moving the shutter **34***d* from the cap **34**Y to the container body **33**Y (moving from the right to the left in FIG. **28**A) and is closed by moving the shutter **34***d* from the container member **33**Y to the cap **34**Y. The shutter **34***d* opens and closes the toner outlet W by moving together with the toner container **32**Y as the container body **33**Y is installed into and released from the toner container frame **70** in the image forming apparatus **100**.

It is to be noted that, FIGS. **18** through **20** show a series of movements when the shutter **34***d* opens the toner outlet W (from the start to the completion of the opening operation). FIGS. **21**A through **21**C are schematic diagrams illustrating the shutter **34***d* (a shutter deformation portion **34***d***2** shown in FIG. **26**) when the shutter **34***d* opens the toner outlet W.

Next, referring to FIGS. **14** **15**, **39**, and **40**, the positioning of the cap **34**Y in the cap holder **73** in the image forming apparatus is described below.

As shown in FIGS. **14** and **15**, a primary positioning hole **34***a* is formed in an upper portion (a ceiling portion) of a front surface of the cap **34**Y, that is, a face perpendicular to the longitudinal direction of the toner container **32**Y and extended in the longitudinal direction of the cap **34**Y. In addition, the primary positioning hole **34***a* is surrounded by a first surrounding wall **34***a***1**, and the first surrounding wall **34***a***1** projects forward from the front surface of the cap **34**Y in the longitudinal direction. The primary positioning hole **34***a* functions as a main positioning reference to determine an installation position of the cap **34**Y of the toner container **32**Y relative to the cap holder **73** in the image forming apparatus **100**. More specifically, a main reference pin **73***a* of the cap holder **73** (see FIGS. **39** and **40**) is fitted into the primary positioning hole **34***a* as the toner container **32**Y to which the cap **34**Y is attached is inserted into the toner container frame **70**.

In addition, a secondary positioning hole **34***b* is formed in a lower portion (a bottom) of the front surface of the cap **34**Y, that is, the face perpendicular to the longitudinal direction of the toner container **32**Y and is extended in the longitudinal direction of the cap **34**Y to an extent not to reach the toner outlet W. In addition, the secondary positioning hole **34***b* is surrounded by a second surrounding wall **34***b***1**, and the second surrounding wall **34***b***1** projects forward from the front surface of the cap **34**Y in the longitudinal direction. The secondary positioning hole **34***b* functions as a sub-positioning reference to determine the installation position of the cap **34**Y of the toner container **32**Y relative to the cap holder **73** in the image forming apparatus **100**. More specifically, a sub-reference pin **73***b* of the cap holder **73** (see FIGS. **39** and **40**) is fitted into the secondary positioning hole **34***b* by moving together with the toner container **32**Y as the toner container **32**Y is inserted into the toner container frame **70**. It is to be noted that the secondary positioning hole **34***b* is elliptical and its vertical diameter is longer than the horizontal diameter thereof.

The position of the cap **34**Y is determined by the above-described reference holes **34***a* and **34***b*. Further, with reference to FIG. **8**, the positioning holes **34***a* and **34***b* are arranged so that a virtual perpendicular lines respectively passing through center positions of the primary positioning hole **34***a* and the secondary positioning hole **34***b* are aligned with the same straight line and also pass through a center position of the round body of the cap **34**Y.

Herein, with reference to FIG. **28**A, the depth of the primary positioning hole **34***a* (length of the main reference pin **73***a* in the longitudinal direction) is longer than the depth of the secondary positioning hole **34***b* (length of the sub-reference pin **73***b* in the longitudinal direction). With this configuration, in installation of the cap **34**Y of the toner container **32**Y into the cap holder **73** of the toner container frame **70**, after insertion of the main reference pin **73***a* into the primary positioning hole **34***a* (main positioning reference) is started, insertion of the sub-reference pin **73***b* into the secondary positioning hole **34***b* (sub-positioning reference) is started. Thus, the cap **34**Y of the toner container **32**Y can be smoothly inserted into the cap holder **73** of the container frame **70**.

In addition, because the primary positioning hole **34***a* whose length in the longitudinal direction is longer is provided in the ceiling portion of the cap **34**Y so that the primary positioning hole **34***a* does not recess inward from the inner face of the round body of the cap **34**Y, adverse effects of the primary positioning hole **34***a* on the conveyance ability (fluidity) of the toner in the cap **34**Y can be prevented or reduced.

Further, although the secondary positioning hole **34***b* provided in the bottom portion of the cap **34**Y, has such a shorter length that the secondary positioning hole **34***b* can be formed in a relatively short space that extends from the front surface of the cap **34**Y to a front end of the toner outlet W, the secondary positioning hole **34***b* can sufficiently function as the sub-positioning reference to determine the position of the toner container **32**Y.

With reference to FIGS. **8** and **14** through **17**, a first engaging member **34***e* and the pair of second engaging members **34***f*, serving as first restriction members, are formed in the ceiling portion of the cap **34**Y so as to position the cap **34**Y in a horizontal direction indicated by arrow Y in FIG. **14**, perpendicular to the longitudinal direction (indicated by arrow X) of the cap **34**Y in the cap holder **73** in the image forming apparatus **100** indicated by arrow Y. Both of the first engaging member **34***e* and the second engaging members **34***f* project upward from the outer circumferential surface of the cap **34**Y (indicated by arrow Z shown in FIG. **14**) symmetrically relative to a virtual perpendicular line passing through the center position of the primary positioning hole **34***a* in cross sectional view perpendicular to the longitudinal direction, that is, a cross sectional view in parallel to the front surface of the cap **34**Y shown in FIG. **8**. In addition, the first engaging member **34***e* and the second engaging members **34***f* are extended along the ceiling of the round body of cap **34**Y in the longitudinal direction indicated by the arrow X in FIG. **14** (in the direction orthogonal to the surface of paper on which FIG. **8** is drawn). In addition, the first engaging member **34***e* and the second engaging members **34***f* engage corresponding engaged portions **73***m* (projecting portions) in the cap holder **73** (see FIGS. **38** and **39**). Therefore, the cap **34**Y is inserted into or released from the cap holder **73** while the horizontal position of the cap **34**Y is restricted by the first engaging member **34***e* and the second engaging members **34***f* respectively engaged with the engaged portions **73***m*. Then, in the state in which the cap **34**Y is set in to the cap holder **73**, the horizontal position of the cap **34**Y is restricted.

More specifically, the first engaging member **34***e* (restriction member) is provided just above the primary positioning hole **34***a* and is almost rectangular in a cross sectional view perpendicular to the longitudinal direction. Further, the first engaging member **34***e* has a projecting engagement portion **34***e***1** that projects forward from the first surrounding wall **34***a***1** of the primary positioning hole **34***a*. As shown in FIG. **14**, the projecting engaging portion **34***e***1** has a tapered tip, that is, its front side end is smaller than the backside end thereof.

On the other hand, the second engaging members **34***f* (restriction member) are formed so as to sandwich the first

engaging member **34***e* from both side, and each engaging member **34***f* is L shaped when viewed in a cross sectional view perpendicular to the longitudinal direction (viewed from a front side of the cap **34**Y shown in FIG. **8**). In FIGS. **14** and **39**, the first engaging member **34***e* engages the two engaged member **73***m*, that is, the first engaging member **34***e* is fitted between the two engaged portion **73***m*, and the second engaging member **34***f* engages the engaged portions **73***m*, that is, the two second engaging members **34***f* sandwich the two engaged portions **73***m* from outside. Herein, in installation of the cap **34**Y into the cap holder **73**, the tapered projecting engaging portion **34***e***1** projecting forward from the edge of the primary positioning hole **34***a* engages the engaged portions **73***m* before the second engaging members **34***f* engage the respective engaged portions **73***m*, and thus the cap **34**Y can be smoothly installed into the cap holder **73**.

With reference to FIGS. **37** through **42**, the cap holder **73** includes four cap-surrounding portions (frames) **731**Y, **731**M, **731**C, and **731**K that surround the caps **34**Y, **34**M, **34**C, and **34**K of the toner container **32**Y, **32**M, **32**C, and **32**K, respectively. The lateral grooves **73***c* that engages the corresponding pair of the lateral protrusions **34***c* of the cap **34**Y of the toner container **32**Y are recessed from both sidewalls of the corresponding cap-surrounding portion **731**Y in the cap holder **73** and is extended in the direction of insertion. In addition, the engaged portion **73***m* that engages the first engaging member **34***e* and the second engaging member **34***f* projects downward from a ceiling of the cap-surrounding portion **731**Y of the cap holder **73**, extending in the direction of insertion.

Further, with reference to FIGS. **14** through **17**, the pair of lateral protrusions **34***c*, serving as a second restriction member, is formed on both sides on the outer circumferential face of the cap **34**Y so as to position the cap **34**Y in a rotation direction indicated by arrow R in FIG. **14** of the cap holder **73** in the image forming apparatus **100**. The lateral protrusions **34***c* (second restriction member) protrude from lateral sides of the cap **34**Y horizontally so as to be arranged in a virtual horizontal line passing through a center position of the line connecting the center position of the primary positioning hole **34***a* and the center position of the secondary positioning hole **34***b*, when viewed in a cross sectional view perpendicular to the longitudinal direction, and is extended in the longitudinal direction, a direction orthogonal to the surface of paper on which FIG. **8** is drawn.

With this configuration, the cap **34**Y is installed into the cap holder **73** while the position of the cap **34**Y in the rotation direction is restricted by the two lateral protrusions **34***c* (second restriction members) engaged with lateral grooves **73***c* (groove) of the cap holder **73** shown in FIG. **38**. Then, in the state in which the cap **34**Y is set in the cap holder **73**, the position of the cap **34**Y in the rotation direction is restricted by the engagement between the lateral protrusions **34**Y and the lateral grooves **71***c*. More specifically, as shown in FIG. **14**, front end tip portions **34***c***1** of the lateral protrusions **34***c* are tapered and their front side ends are smaller than the back side ends thereof.

As described above, in installation process of the cap **34**Y into the cap holder **73**, initially, the first engaging member **34***e* engages the engaged portions **73***m*, then, the second engaging members **34***f* engage the engaged portions **73***m*. Subsequently, the two lateral protrusions **34***c* whose front side tip **34***c***1** is tapered engage the lateral grooves **73***c*. Accordingly, the cap **34**Y can be smoothly installed into the cap holder **73** while the position of the cap **34**Y is reliably restricted by the restriction members **34***e*, **34***f*, and **34***c*.

With reference to FIGS. **14** and **15**, the RFID chip **35**, serving as the electronic data storage, is set in the mounting section **34***k* provided on the front surface of the cap **34**Y. The mounting section **34***k* to accommodate the RFID chip **35** is enclosed by an outer rib (frame) **34***k***1** protruding forward from the front surface of the cap **34**Y and is positioned between the primary positioning hole **34***a* and the secondary positioning hole **34***b*.

The RFID chip **35** is kept at a position facing the antenna **73***e*, a predetermined distance away from the antenna **73***e* in the cap holder **73***e* in the state in which the cap **34**Y is set in the cap holder **73** of the toner container holder **70**. Thus, the RFID chip **35** contactlessly communicates with the antenna **73***e* (wireless communication).

Herein, because the RFID chip **35** is mounted between the primary positioning hole **34***a* (main positioning reference) and the secondary positioning hole **34***b* (sub-positioning reference) in the present embodiment, the position of the RFID chip **35** can be determined with a higher degree of accuracy relative to the antenna **73***e* of the cap holder **73**. Accordingly, the communication failure caused by positional deviation of the RFID chip **35** relative to the antenna **73***e* (antenna for RFID chip) can be prevented.

It is to be noted that the projecting engaging portion **34***e***1** and the two projecting members **34***m* project forward more than the outer rib **34***k***1** of the mounting section **34***k* surrounding the RFID chip **35**. Therefore, even when the user puts the toner container **32**Y on a given object with the cap **34**Y on the lower side, because the mounting section **34***k* accommodating the RFID chip **35** contacts the object directly, the RFID chip **35** is less likely to receive damage directly and be broken.

With reference to FIGS. **14**, **15**, and **30**A through **30**D, compatibility (color discrimination) of the toner containers **32**Y, **32**M, **32**C, and **32**K is described below.

FIGS. **30**A through **30**D show the vicinity of the inserting openings **710**Y in inserting portions **71**Y, **71**M, **71**C, and **71**K in the inserting portion **71** (shown in FIG. **4**) of the toner container frame **70**.

As shown in FIGS. **14** and **15**, the discrimination portions **34***g* and **34***h* used for identifying compatibility are provided on the outer circumferential surface of the cap **34**Y. When the toner container **32**Y is properly inserted into the toner container frame **70**, respective discrimination protrusions (clawed shape members) of the discrimination portions **34***g* and **34***h* engage corresponding recessed engagement portions **71***g* and **71***h* formed in the insertion portion **71** of the toner container frame **70** shown in FIGS. **30**A through **30**D.

It is to be noted that, in the description below, the discrimination protrusion portions **34***g* and **34***h* and the engagement portions **71***g* and **71***h* for yellow, magenta, cyan, and black are respectively given reference character Y, M, C, and K positioned between the reference numeral and the reference character g or h.

More specifically, in FIG. **30**A, the discrimination portions **34**Yg and **34**Yh on the cap **34**Y (yellow) is formed so that the discrimination protrusions of the description portions **34**Yg and **34**Yh are fitted into only the recessed engagement portions **71**Yg and **71**Yh provided around the inserting opening **710**Y formed in the inserting portion **71**Y of the toner container frame **70**. In FIG. **30**B, the discrimination portions **34**Cg and **34**Ch on the cap member **34**C (cyan) is formed so that the discrimination protrusion of the description portions **34**Cg and **34**Ch are fitted into only the recessed engagement portions **71**Cg and **71**Ch provided around the inserting opening **710**C formed in the inserting portion **71**C of the toner container frame **70**. In FIG. **30**C, the discrimination protrusion portions **34**Mg and **34**Mh on the cap member **34**M (ma-

genta) is formed so that the discrimination protrusions of the discrimination portions **34**Mg and **34**Mh are fitted into only the recessed engagement portions **71**Mg and **71**Mh provided around the inserting opening **710**M formed in the inserting portion **71**M of the toner container frame **70**. In FIG. **30**D, the discrimination protrusion portions **34**Kg and **34**Kh on the cap member **34**K (black) is formed so that the discrimination protrusions of the discrimination portions **34**Kg and **34**Kh are fitted into only the recessed engagement portions **71**Kg and **71**Kh provided around the inserting opening **710**K formed in the inserting portion **71**K of the toner container frame **70**.

As described above, because arrangement of the discrimination protrusions in the discrimination portions **34**Yg and **34**Yh used for yellow (see FIGS. **8** and **9**), the discrimination portions **34**Mg and **34**Mh used for magenta, the discrimination portions **34**Cg and **34**Ch used for cyan, and the discrimination portions **34**Kg and **34**Kh used for black are positioned differently from each other, each of the recessed engagement portions **71**Yg and **71**Yh, **71**Mg and **71**Mh, **71**Cg and **71**Ch, and **71**Kg and **71**Kh can engage only the corresponding color of the toner container **32** among the toner containers **32**Y, **32**M, **32**C, and **32**K in accordance with the identification of the discrimination portions **34**Yg and **34**Yh **34**Mg and **34**Mh **34**Cg and **34**Ch, and **34**Kg and **34**Kh. Accordingly, because the discrimination portions **34**Cg and **34**Ch can prevent the toner container **32**Y, **32**M, or **32**K that contains toner other than cyan toner from being inserted into the connected to the toner container frame **71**C (for cyan), failure that the desired color image cannot be formed can be prevented. That is, due to the discrimination portions **34***g* and **34***h*, the setting (color discrimination) error of the toner container **32** in the toner container frame **70** can be prevented.

Herein, the discrimination portions **34***g* and **34***h* can have the respective color identification by cutting off some of the discrimination protrusions formed therein differently in accordance with the color of toner contained in that toner container **32**. When the certain protrusion from a total of eight protrusions is cut off from the discrimination portions **34***g* and **34***h* formed on the cap member **34** as shown in FIG. **8** with a cutting jig, (e.g., nippers or cutters), various types of the discrimination portions **34***g* and **34***h* can be formed. In the present embodiment, the four different discrimination portions **34***g* and **34***h* can be formed as shown in FIGS. **30**A through **30**D. In this configuration, in manufacturing process, manufacturing multiple different types of molds in accordance with the number of the type of the toner containers **32** (cap members **34**) is not required. Instead, the cap members **34**Y **34**C, **34**M and **34**K for compatibility can be manufactured by using only one type of the mold, and therefore, the manufacturing cost of the multiple types of the toner containers **32** can be reduced. It is to be noted that, in the present embodiment, although the four types of the cap members **34** are formed as shown in FIGS. **30**A through **30**D, other types of cap members can be formed with a different combination of the discrimination protrusions by cutting off unnecessary discrimination protrusions differently.

FIGS. **31**A through **31**C shows variations of the inserting portions **71**, and the toner containers **32**Y, **32**M, **32**C, and **32**K are differently arranged in the inserting portions **71** shown in FIGS. **31**A through **31**C. In FIGS. **31**A through **31**C, wherever the discrimination protrusions in the discrimination portions **34***g* and **34***h* are arranged, the discrimination portion **34***g* (recessed engagement portion **71***g*) does not interfere with the discrimination portions **34***h* (recessed engagement portion **71***h*) provided adjacent to the inserting opening **710** in the inserting portions **71**. The four inserting openings **710**Y, **700**M, **710**C, and **710**K in the inserting portion **71** are arranged not in horizontal but arranged obliquely, so that the upper discrimination portion **34***g* (**34**Yg) of, for example, the toner container **32**Y for yellow is located higher than the lower discrimination portion **34***h* (**34**Mh) of the adjacent toner container **32**M for magenta. It is to noted that when viewed from a front side in the cross sectional view, perpendicular to the longitudinal direction in FIGS. **31**A through **31**C, the respective protrusions (clawed shape members) of the discrimination portions **34***g* project outward from the outer circumferential surface of the cap member **34** in parallel to each other, and the respective protrusions (clawed shape members) of the discrimination portions **34***h* project outward in parallel to each other.

In addition, the discrimination portions **34***g* and **34***h* are arranged so as to sandwich a center vertical line of the respective cap members **34** when vied from front side shown in FIG. **8**. That is, one of the discrimination protrusions of the discrimination portions **34***g* and **34***h* are located on the right side of the center vertical line of the cap member **34** (see FIG. **31**) and the other of the discrimination protrusions of the discrimination portions **34***g* and **34***h* are located on the left of the center vertical line. Accordingly, when any of the incorrect toner container **32**M, **32**C, and **32**K is inserted into the opening **710**Y in the inserting portion **71**Y of the container frame **70**, deformation of the incorrect toner containers **32**M, **32**C, or **32**K caused by the force localized to one side of the cap member **34**M, **34**C, **34**K, exerted from the discrimination protrusions pressing against the vicinity of the recessed engagement portions **71***g* and **71***h* of the inserting portion **71**Y can be prevented. That is, when any incorrect toner container **32** M, **32**C, or **32**K is inserted into the opening **710**Y in the inserting portion **71**Y of the container frame **70**, the pressing force exerted from the respective discrimination protrusions of the **34***g* and **34***h* can be distributed to the vicinity of the inserting opening **710**Y of the toner container frame **70** on both sides in a balanced manner in the cap member **34**M, **34**C or **34**K. In order to accomplish the effect, it is preferable that the discrimination portions **34***g* and **34***h* are separated from each other with differences between the angle positions thereof on the circumferential surface of the cap **34**Y shifted ranging from 120° to 240°.

It is to be noted that, in FIGS. **14** and **15**, the shutter **34***d* includes a pair of handle parts **34***d***11** and a pair of the shutter sliders **34***d***12**, and a shutter container **34***n* of the second container body **34**Y**2** includes a pressing rail **34***n***2**, a front side tip portion **34***n***21** of the pressing rail **34***n***2**, and a pressure receiving face **34***n***3**.

With reference to FIG. **15**, the notch **34***x* is formed on the outer conferential surface of the cap **34**Y, and the gear **33***c* in the container body **33**Y is partly exposed from the notch **34***x* when viewed from outside. In the state in which the toner container **32**Y is set in the toner container frame **70**, the gear **33***c* exposed from the notch **34***x* of the cap **34**Y engages the driving gear **81** provided in the cap holder **81** (see position broken line in FIG. **38**), and therefore, the container body **33**Y is rotated with the gear **33***c* by the driving gear **81**.

With reference to FIGS. **16** and **17**, the shutter container **34***n* (containing space) is formed in the lowest space of (a second cap body **34**Y**2** shown in FIG. **25** of) the cap **34**Y. The shutter container **34***n* (containing space) is for containing a part of the shutter **34***d* (shutter deformation portion **34***d***2** in the shutter **34***d* see FIG. **26**) when the shutter **34***d* opens the toner outlet W. The space forming the shutter container **34***n* is a substantially rectangular parallelepiped projecting downward from the insertion opening **34***z* shown in FIG. **29**. (The shutter container **34***n* is defined by a bottom side faces of the second cap body **32**Y**2** and the insertion opening **34***z*.)

The shutter container **34***n* accommodates the shutter deformation portion **34***d***2** in a deformation state, meaning that the shutter deformation portion **34***d***2** is elastically deformed (pivoted) upward around a connection portion with a main shutter portion **34***d***1** shown in FIG. **22**. Herein, with reference to FIGS. **14** and **15**, the slide groove **34***n***1** functioning as an outside rail to guide the shutter member **32***d* to open and close with a shutter rail **34***t* (see FIG. **22**) functioning as an inside rail is formed on an interior wall of the shutter container **34***n*. It is to be noted that the configuration and operation of the shutter **34***d* are described in further detail later.

In addition, with reference to FIG. **15**, the pressing rail **34***n***2** is formed on one side of an outer surface of the shutter container **34***n*. Referring to FIGS. **34** and **42**, a pressing member **72***c* is formed on the bottle holder **72** and is pressed by a compression spring **72***e*. The pressing rail **34***n***2** engages the pressing member **72***c* on the bottle holder **72** to determine the position of the cap **34**Y passing above the bottle holder **72** while the toner container **32**Y is inserted into the toner container frame **70**. The pressing rail **34***n***2** is a recessed portion (groove) and is extended in parallel to the longitudinal direction of the toner container **32**Y (direction of insertion). That is, the pressing rail **34***n***2** on the side face of the shutter container **34***n* is formed of a recessed portion, an upper projecting portion, and a lower projecting portion. Further, the pressing rail **34***n***2** extends an entire length of the shutter container **32***n*, and the pressing rail **34***n***2** does not have a wall portion but opens on each end. A front side tip portion **34***n***21** of the lower projecting portion of the pressing rail **34***n***2** is tapered, that is, in the front side tip portion **34***n***21**, a tip front edge of the lower projecting portion of the pressing rail **34***n***2** is sloped.

Further, with reference to FIG. **14**, the pressure receiving face **34***n***3** is formed on the other side on the outer surface of the shutter container **34***n*. In FIGS. **34** and **42**, a pressure receiving member **72***d* is formed in the bottle holder **72** and slides on the pressure receiving face **34***n***3** to determine the position of the cap **34**Y passing above the bottle holder **72** while the toner container **32**Y is inserted into the toner container frame **70**.

With this configuration, when the toner container **32**Y installed into the toner container frame **70** and just before the cap **34**Y is installed into the cap holder **73**, or when the toner container **32**Y released from the toner container frame **70** and just after the cap **34**Y is released from the cap holder **73**, the pressing rail **34***n***2** is pressed by engaging the pressing member **72***c* biased by the compression spring **72***e*. Then, the pressure receiving face **34***n***3** receives the pressing force while sliding on the pressure receiving member **72***d*.

Undergoing these processes, the position of the cap **34**Y just before inserted into the cap holder **73** or just after released from the cap holder **73** can be restricted.

Herein, the cap **34**Y communicates with the container body **33**Y through the opening A, and the toner discharged from the opening A is discharged through the toner outlet W (movement indicated by arrow s shown in FIG. **3**). More specifically, in the present embodiment, with reference to FIG. **28**A, the lateral cylindrical hollow B (space) extends in the longitudinal direction (lateral direction in FIG. **28**A). In FIG. **29**, the inner diameter of the hollow B is set smaller than an inner diameter of the insertion opening **34***z* into which the front face of the container body **33**Y is inserted. In addition, the toner dropping route C that is a cylindrical hollow extends from a lower face of the lateral cylindrical hollow B to the outermost face of the toner outlet W and has a predetermined cross-sectional area, functioning as a predetermined flow channel area (flow channel cross-sectional area).

With this configuration, the toner discharged from the opening A of the container body **33**Y to the hollow B in the cap **34**Y is smoothly discharged outside (to the toner tank **61**Y) by dropping under its own weight.

With reference to FIGS. **22** through **25**, the cap **34**Y (in which the shutter **34***d* and the shutter seal **36** are detached) is constituted of a first cap body **34Y1** and a second cap body **34Y2** by welding. More specifically, in a manufacturing process, the lateral protrusions **34***c* and a shutter support section **34Y1**B (lower portion) provided in the first cap body **34Y1** are fitted into corresponding notches **34Y2***b* and **34Y2***c* of the second cap body **34Y2**, and then, the first cap body **34**Y and the second cap body **34Y2** are bonded together (welded) so that an inner face **34Y2***a* of the second cap body **32Y2** is in direct contact with an engagement portion **34Y1***c*.

It is to be noted that, with reference to FIGS. **23** and **24**, a circular cap seal **37**, serving as a cap seal, is attached to a back side edge of the first cap body **34Y1** (facing the opening A formed in the container body **33**Y). The cap seal **37** that is formed of an elastic material (e.g., foam resin), such as foam polyurethane and is for filling a gap between the vicinity of the opening A of the container body **33**Y and the backside edge of the first cap body **34Y1**.

In addition, with reference to FIG. **23**, the mounting section **34***k* in which the RFID chip **35** is set is formed on the front surface of the first cap body **34Y1**. The outer rib (wall frame) **34***k***1** that is an outer frame of the mounting section **34** protrudes forward from the front surface of the first cap body **34Y1**. Four corner frames **34***k***2** to fix four corners of the rectangular RFID chip **35** are provided at four corners of the outer rib (wall frame) **34***k***1**, inside the mounting section **34***k*. Because RFID chip **35** is set on the corner frames **34***k***2**, an electronic device formed on a back side of the RFID chip **35**, facing the first cap body **34Y1**, can be set contactlessly with the front surface of the first cap body **34Y1**.

It is to be noted that, in setting process of the RFID chip **35** in the mounting section **34***k*, after the RFID chip **35** is put on the corner frames **34***k***2**, the corner frames **34***k***2** are partly jointed with the four corners of the RFID chip **35** by melting the part of the corner frames **34***k***2** with heat and pressure and cooling it to solidify it.

In addition, as shown in FIGS. **23** and **24**, the two shutter rails **34***t* (rail members) are provided on the both side faces of the shutter support section **34Y1**B (the lowest portion) of the first cap body **34Y1** (cap **34**Y). The first cap body **34Y1** is formed by a round body **34Y1**A and the shutter support section (bottom portion) **34Y1**B in which the toner outlet W is formed. A side rib **34***p* and the shutter rail **34***t* project outward from each of side faces **34***q* of the shutter support section **34Y1**B. Each shutter rail **34***t* projects along an bottom surface of the shutter support section **34Y1**B and is formed with a part of outer vertical face **34***s* (vertical face) and a part of a horizontal face **32***t***2** that is a upper face of the projection portion of the shutter rail **34***t*.

The shutter **34***d* is movably guided by the shutter rails **34***t* in the longitudinal direction relative to the cap **34**Y to open and close the toner outlet W. The shutter rail **34***t* is formed on the two vertical faces **34***s* that extend upward from the lowest surface forming the toner outlet W (see FIG. **28**A), that is, the shutter rail **34***t* is constituted of a part of the vertical face **34***s* and the upper face **34***t***2**.

In addition, the pair of vertical faces **34***s* is continuously formed from a front side end of the shutter rail **34***t* to the projecting portion in the longitudinal direction (also shown in FIG. **43**). That is, the two projecting portions **34***m* (shaped like horns) that project forward from the front surface of the cap **34**Y are formed. The two projecting portions **34***m* are

positioned close to the lower edge of the secondary positioning hole **34***b* and are arranged to sandwich the secondary positioning hole **34***b*. The outer side surfaces of the two projecting members **34***m* are included in the outer vertical surfaces **34***s*. That is, the outer vertical surfaces of the projecting portions **34***m* are substantially aligned with the respective outer side surfaces (vertical surfaces) **34***s*.

With reference to FIG. **45**, the outer side surfaces **34***s* contact first arms **73***d***1** of a pair of shutter closing members **73***d* (shutter retainer) in the cap holder **73**. More specifically, the position of the shutter **34***d* in the cap **34**Y set in the cap holder **73** is determined by the shutter closing members **73***d* (shutter retainer). Each shutter closing member **73***d* includes the wide long first arm **73***d***1** that contacts the side vertical face **34***s* of the shutter support section **34Y1**B, a short second arm **73***d***2**, and a rotary shaft **73***d***3** disposed in a center portion thereof.

Herein, each projection portion **34***m* is a member to restrain the shutter closing members **73**Y from releasing the shutter **34***d*. In FIG. **45**, when the toner container **32**Y is released from the toner container frame **70**, a timing at which the shutter closing member **73***d* releases the outer vertical faces **34***s* held by the first arms **73***d***1** can be delayed by extending the outer vertical faces **34***s* longer by including the projection portion **34***m* in the direction of insertion, from a timing at which the shutter closing members **73***d* completely close the shutter **34***d*.

Accordingly, the toner container **32**Y can be prevented from being released from the image forming apparatus **100** before the shutter **34***d* fully closes the toner outlet W.

In particular, because the two projecting portion **34***m* is positioned to projects from the edge of the primary positioning hole **34***a* in the direction of insertion (longitudinal direction), when the cap **34**Y is fully released from the cap holder **73**, the hold state of the shutter **34***d* held by the first arm **73***d***1** is finally released, and thus the toner outlet W is reliably closed by the shutter **34***d*.

In addition, in FIGS. **23** and **24**, the first cap body **34Y1** includes the primary positioning hole **34***a* (main positioning reference) and the secondary positioning hole **34***b* (sub-positioning reference) for determining the position of the cap **34**Y as well as the first engaging member **34***e* and the lateral protrusion **34***c* for restriction of position, in addition to the toner outlet W.

Therefore, when the cap **34**Y is formed by jointing the two molded pieces (first cap body **34Y1** and the second cap body **34Y2**) by molding or thermal welding, the positional fluctuation of the toner outlet W of the cap **34**Y relative to the toner supply opening **73***w* of the cap holder **73** caused by fluctuations in the accuracy of the molding or thermal welding can be prevented. Therefore, shortage of supplied toner caused by the position failure of the toner outlet W can be prevented. It is to be noted that the structure and the operation of the shutter closing (control) member **73***d* (shutter retainer) are described further detail later with reference to FIGS. **43** through **45**.

Herein, the shutter **34***d* is attached to the bottom portion of the cap **34**Y, and an upper face of the shutter **34***d* facing the toner discharge outlet W is sealed with the shutter seal **36** (seal member).

Next, referring to FIGS. **18** through **21**C, **26**, and **27**, the configuration and operation of the shutter **34***d* is described below.

As shown in FIGS. **18** through **20**, the shutter **34***d* opens and closes the toner outlet W in synchronization with the installation of the toner container **32**Y into the toner container frame **70**.

FIG. **26** is a perspective view illustrating the shutter **34***d* before attached to the cap **34**Y. FIG. **27** shows the shutter **34***d* viewed from another angle different from that shown in FIG. **26** by approximately 90 degrees. As shown in FIGS. **26** and **27**, the shutter **34***d* includes the main shutter portion **34***d***1** that is planar and the shutter deformation portion **34***d***2**. The shutter deformation portion **34***d***2** is elastic and projects backward from the back end face of the main shutter portion **34***d***1** and the thickness thereof is thinner than that of the main shutter portion **34***d***1**.

The main shutter portion **34***d***1** includes a main planar body **34***d***10**, the pair of handle parts **34***d***11**, the pair of shutter sliders **34***d***12**, and a pair of shutter-rail enragement portions **34***d***15**. The pair of handle parts **34***d***11** stands upward on front edges of side faces of the main planar body **34***d***10**. Each of the shutter sliders **34***d***12** includes stand portions standing upward on a side face of the main planar body **34***d***10** and projecting portions projecting outward from side faces of the side edges of the main planar body **34***d***10** (from top of the stand portion of the standing portion thereof), and the outer projecting faces of the shutter slider **34***d***12** extend in parallel to the direction of insertion of the toner container **32**Y. Each shutter-rail enragement portion **34***d***15** is formed on an inner face of the standing portion of the shutter slider **34***d***12** to project inward of the main planar body **34***d***10** (opposite the direction in which the projecting portion of the shutter slider **32**Yd**12** projects), positioned at a predetermined distance from the shutter seal **36**.

In addition, the length of the shutter slider **32Y12** in the direction of insertion of the toner container **32**Y is equal or substantially equal to the length from back side end of the shutter rail **34***t* to the shutter projection **34***t***1** formed on the shutter rails **34***t* in the longitudinal direction when the shutter **34***d* is attached to the first cap body **34Y1** (see FIGS. **23** and **24**). It is to be noted that the length of the slide groove **34***n***1** formed in the shutter container **34***n* of the second cap body **34Y2** (see FIG. **25**) in the direction of insertion is almost equal to the length of the shutter slider **34***d***12**.

Then, while the shutter sliders **34***d***12** of the main shutter portion **34***d***1** is fitted into the slide grooves **34***n***1** (outside rail) of the second cap body **34Y2**, and the shutter-rail engagement member **34***d***15** engages the shutter rails **34***t* (inside rail) of the first cap body **34Y1** by sandwiching the shutter rail **34***t* (inside rail) between the shutter-rail engagement member **34***d***15** and the shutter seal **36**, the shutter **34***d* is moved along the rail members (the slide groove **34***n***1** and the shutter rail **34***t*). Thus, the main shutter portion **34***d***1** of the shutter **34***d* opens and closes the toner outlet W.

Herein, the upper face of the main planar body **34***d***10** of the main shutter portion **34***d***1** that faces the toner outlet W is sealed with the shutter seal **36** (seal member). The shutter seal **36** that is formed of elastic material (e.g., foam resin) is for preventing leakage of the toner between the main shutter portion **34***d***1** and the toner outlet W when the toner outlet W is closed by the main shutter portion **34***d***1** of the shutter **34***d*.

In the present embodiment, as shown in FIGS. **26** and **27**, the shutter seal **36** is extended from the backside end of the main shutter portion **34***d***1** to a position projecting forward from the tip face of the shutter **34***d* in the longitudinal direction (direction of insertion). Therefore, when the cap **34**Y is installed into the cap holder **73**, the tip portion (projecting portion) of the shutter seal **36** closely contacts a wall **73***w***1** (see FIG. **38**) surrounding the toner supply opening **73***w*. Thus, leakage of the toner from the vicinity of the toner supply opening **73***w* can be prevented with the shutter seal **36**.

As shown FIGS. **21**A through **21**C, **26**, and **27**, the shutter deformation portion **34***d***2** is integrally formed with the main

shutter portion **34***d***1** and is elastically deformable (pivotable) in a vertical direction around a connection point **34***d***23** between the shutter deformation portion **34***d***2** and the main shutter portion **34***d***1** (see broken circle in FIGS. **21**A through **21**C), as an pivoting axis. The shutter deformation portion **34***d***2** is positioned on the container body **33**Y side in the longitudinal direction relative to the main shutter portion **34***d***1** (see FIG. **18**). In FIG. **21**A through **21**C, and **27**, the shutter deformation portion **34***d***2** includes a pair of stoppers **34***d***22** and a stopper release member **34***d***21**. Each stopper **34***d***22** is a wall formed on a back side tip portion of the shutter deformation portion **34***d***2** in a direction in which the shutter **34***d* is opened (provided on the left side in FIGS. **21**A through **21**C), that is, the stopper **34***d***22** is positioned farthest from the main shutter portion **34***d***1**, in the shutter deformation portion **32***d***2**.

Because backside faces **34***d***220** of the stoppers **34***d***22** contact a contact face **34***n***5** of the shutter container **34***n*, the stoppers **34***d***22** restrict the movement of the shutter **34***d* in the direction in which the shutter **34***d* is opened. That is, when the toner container **32**Y is not set in the image forming apparatus **100***he* backside face **34***d***220** of the stopper **34***d***22** of the shutter **34***d* contacts the contact face **34***n***5**, and the stopper **34***d***22** can prevent the shutter **34***d* from moving toward the release position of the toner outlet W.

The stopper-release member **34***d***21** (stopper release projection) projects downward from a flat bottom face of the shutter deformation portion **34***d***2**. Referring to FIGS. **71**A through **71**C, the stopper release member **34***d***21** is for moving the stopper **34***d***22** upward as the shutter deformation portion **34***d***2** elastically deforms upward when external force is exerted on the shutter deformation portion **34***d***2**, and thus the contact between the backside face **34***d***220** of the stopper **34***d***22** and the contact face **34***n***5** is released.

The stopper release member **34***d***21** is a mountain-shaped projection formed between the stopper **34***d***22** and the connection point **34***d***23** between the main shutter portion **34***d***1** and the shutter deformation portion **34***d***2**. The stopper release member **34***d***21** is sloped on both sides in the direction in which the shutter **34***d* is opened.

Additionally, with reference to FIGS. **32** and **42**, a stopper-release pressing member **72***b* that is a trapezoidal rib is provided in the bottle holder **72**, in a front end of the bottle receiving face **72***a* (a downstream side in which the toner container **32**Y is installed into the bottle holder **72**). The stopper-release pressing member **72***b* is for pressing the stopper release member **34***d***21** of the shutter **34***d* to releasing the contact between the stopper **34***d***2** and the contact face **34***n***5**.

With this configuration, in conjunction with insertion of the toner container **32**Y into the toner container frame **70**, the sloped side of the stopper release member **34***d***21** contacts the stopper-release pressing member **72***b* and then the stopper release member **34***d***21** climbs onto the stopper-release pressing member **72***b*. Thus, with the stopper-release member **34***d***21** pushed up by the stopper-release pressing member **72**, that is, with the external force from below, the shutter deformation portion **34***d***2** is deformed upward and the stopper **3422** is moved up. Thus, the contact between the backside face **34***d***220** of the stopper **34***d***22** and the contact face **34***n***5** is released, and the shutter **34***d* becomes movable in the direction in which the shutter **34***d* is opened

Next, with reference to FIGS. **21**A through **21**C, the operation of the shutter **34***d* relative to the shutter container **34***n* of the cap **34**Y in synchronization with the installation of the toner container **32**Y into the toner container frame **70** is described below. It is to be noted that the positions of the shutter **34***d* shown in FIGS. **21**A, **21**B, and **21**C respectively correspond in respective positions to the shutter member **34***b* those relative to the second cap body **34Y2** shown in FIGS. **18**, **19**, and **20**. When the insertion of the toner container **32**Y into the toner container frame **70** is started, the shutter container **34***n* starts moving in the direction of insertion (from left side to right side in FIGS. **21**A through **21**C).

In a state shown in FIG. **21**A, because the stopper release member **34***d***21** does not reach the stopper-release pressing member **72***b* in the bottle holder **72**, the movement of the shutter **34***d* in the opening direction is restricted by contacting the backside face **34***d***220** of the stopper **34***d***22** with the contact face **34***n***5** that is front end face of the shutter container **34***n*.

Then, when the installation process of the toner container **32**Y proceeds, in a state shown in FIG. **21**B, the stopper release member **34***d***21** is pressed up by the stopper-release pressing member **72***b*, and the shutter deformation portion **34***d***2** elastically deforms (pivots) around the connection point **34***d***23** between the shutter deformation portion **34***d***2** and the main shutter portion **34***d***1**, indicated by a broken circle shown in FIG. **21**B. As a result, the contact between the backside face **34***d***220** of the stopper **34***d***22** and the contact face **34***n***5** of the shutter container **32***n* is released, and the shutter **34***d* become movable relative to the opening direction.

Subsequently, the front side tip of the main shutter portion **34***d***1** of f the shutter **34***d* contacts the wall **73***w***1** surrounding the toner supply opening **73***w* in four directions (see FIGS. **38** and **39**), and the movement of the shutter **34***d* on the cap holder **73** of the toner container frame **70** is restricted. Namely, the shutter **34***d* is stopped relative to the toner container frame **70** in the longitudinal direction. However, the toner container **32**Y is further moved in the direction of insertion, and therefore, the shutter **34***d* is moved relative to the toner container **32**Y in the opening direction. That is, the shutter **34***d* is moved relative to the toner container **32**Y to the container body **33**Y side from the position shown in FIG. **21**B to the position shown in FIG. **21**C, and then, the shutter **34***d* is accommodated by the shutter container **32***n* (container space).

Then, in the state shown in FIG. **21**C, the toner outlet W is fully opened by moving the cap **34**Y relative to the cap holder **73**, that is, moving the shutter **34***d* relatively to the cap **34**Y in the opening direction. At this time, the stopper release member **34***d***21** of the shutter **34***d* is stored in a notch **34***n***6** formed on bottom face of the shutter container **34***n* (see FIG. **20**).

As described above, in the toner container **32**Y according to the present embodiment, the shutter **34***d* includes the main shutter portion **34***d***1** and the shutter deformation portion **34***d***2** that elastically pivots around the connection point **34***d***23** therebetween, and the shutter deformation portion **34***d***2** includes the stopper **34***d***21** to restrict the movement of the shutter **34***d* in opening direction when the toner container **32**Y is not set in the image forming apparatus **100**. Therefore, when the toner container **32**Y is not installed, the shutter **34***d* can be prevented from opening the toner outlet W spontaneously. In other words, only when the toner container **32**Y is installed into the image forming apparatus **100**, the shutter **34***d* opens the toner outlet W in synchronization with the installation thereof.

Herein, the shutter-rail engagement members **34***d***15** (see FIG. **26**) also function as second stoppers to restrict the movement of the shutter **34***d* in a closing direction (direction opposite the direction in which the stopper **34***d***22** restricts the movement of the shutter **34***d*) by contacting a second contact face **34***t***3** (front side end wall of the shutter rail **34***t*) indicated by a broken circle shown in FIGS. **22** and **23**. More spherically, when the shutter **34***d* changes the state from an opening

state in which the shutter **34***d* opens the toner outlet W (see FIG. **20**) to a closing state in which the shutter **34***d* closes the toner outlet W (see FIG. **18**), the position of the shutter **34***d* in close state is determined by contacting the shutter-rail engagement member **34***d***15** of the shutter **34***d* with the second contact face **34***t***3** on the shutter rail **34***t* on front side of the closing direction and by contacting the backside face **34***d***220** of the stopper **34***d***22** with the contact face **34***n***5** of the shutter container **34***n* on the back side of the closing direction. At this time, when the shutter-rail engagement portions **34***d***15** contact the second contact faces **34***t***3** immediately after passing over the projection portion **34***t***1** on the shutter rail **34***t* (see FIGS. **23** and **24**), the user can feel the click sensation and recognize that the shutter **34***d* fully closes the toner outlet W.

It is to be noted that, as shown in FIGS. **22** through **24**, each rib **34***p* extended in the longitudinal direction projects from the vertical face **34***q* and is positioned above the shutter rail **34***t*, and outer side faces of the rib **34***p* are aligned with the outer vertical face **34***s*. Each rib **34***p* prevents the first arm **73***d***1** of the shutter closing member **73***d* from entering a gap between the shutter rail **32***t* and the rib **34***p* when the outer vertical face **34***s* of the shutter rail **34***t* is held by the first arm **73***d***1**. That is, the distance between the shutter rail **34***t* and the rib **34***p* (height of the recess) is narrower (lower) than the height of the first arm **73***d***1** (the length in a direction orthogonal to the surface of paper on which FIG. **45** is drawn).

It is to be noted that the rib **34***p* requires to include only a projections projecting laterally (in a direction orthogonal to the surface of paper on which FIG. **28**A is drawn.) and a portion extending in the longitudinal direction (lateral direction in FIG. **28**A), and therefore, the above-described extending vertical side surface is not always required.

Additionally, referring to FIGS. **26** and **27**, the pair of handle parts **34***d***11** is provided on the both side face in the front side of the main shutter portion **34***d***1**.

As shown in FIGS. **43** through **45**, each handle part **34***d***11** is held by the second arm **73***d***2** of the shutter closing members **73***d* (shutter retainer). Each handle part **34***d***11** includes a sidewall **34***d***11***c* standing from a/the side edge of the main planar body **34***d***10** and also function as a sidewall of the main planar body **34***d***10**, an engagement wall **34***d***11***a* standing on a/the front end of the main shutter portion **34***d***1**, and a movement restriction wall **34***d***11***b* extending in parallel to the direction of insertion and provided in an upper portion of the handle part **34***d***11**, above the sidewall **3411***c* in FIG. **26**.

As shown in FIGS. **38** and **42**, the shutter closing member **73***d* (shutter retainer) is provided on the inner bottom face of the cap holder **73** and is disposed upstream from the toner supply opening **73***w* in the direction of insertion of the toner container **32**Y. The pair of shutter closing members **73***d* each of which is hoof-shape is arranged so as to face each other in a lateral direction in FIG. **43**, and is rotatable around the rotary shaft **73***d***3** in which a torsion coil spring **73***f* (see FIG. **42**) is provided.

With this configuration, when the shutter **34***d* opens and closes the toner outlet W, the handle part **34***d***11** is held by the second arm **73***d***2** of the shutter closing member **73***d* (shutter retainer), and the outer vertical face **34***s* of the shutter support section **34**Y**1**B of the cap **34**Y is held by the first arm **73***d***1**, thus determining the positions of the shutter **34***d* and the cap **34**Y. Therefore, the position of the shutter **34***d* and the cap **34**Y in the cap holder can be determined, and opening and closing operation of the shutter **34***d* can be smoothly performed.

At this time, the second arm **73***d***2** of each shutter closing members **73***d* (shutter retainer) holds the sidewall **34***d***11***c* of the handle part **34***d***11** in the main shutter portion **34***d***1**, and the movement restriction wall **34***d***11***b* prevents the handle part **34***d***11** from moving relative to the second arm **73***d***2**. The engagement wall **34***d***11***a* engages a recessed portion of the second arm **73***d***2**, which is described in further detail later.

Herein, with reference to FIGS. **20**, **45**, and **47**, the shape of the toner outlet W is described below.

In FIGS. **20** and **45**, the toner outlet W, formed in the cap **34**Y, is opened and closed by the above-described shutter **34***d* and is hexagonal when viewed from the lower side of the cap **34**Y. More specifically, a rim **34***r* that projects downward from a lowest face of the shutter support section **34**Y**1**B in the cap **34**Y is positioned forms enclosure of the hexagonal toner outlet W. The enclosure of the rim **34***r* is sharpened toward both ends away from a center position of the toner outlet W in the direction of insertion and includes tips **34***r***1** positioned on both sides of the rim **34***r* in the longitudinal direction (vertical direction in FIG. **45**) of the toner container **32**Y. That is, the width of the toner outlet W is reduced with increases in the distance from the center position of the toner outlet W. Specifically, when viewed from the lower side, the rim **34***r* is hexagonal and includes two pairs of side rims **34***r***10** that form apexes (tips **34***r***1**) and a pair of parallel-side rims **34***r***2** extending in the longitudinal direction (vertical direction in FIG. **45**). Then, the toner outlet W is hexagonal in conformity with the shape of the hexagonal rib **34***b*.

As descried above, the width (length in the direction perpendicular to the longitudinal direction of the of the toner container **32**Y) of the rim **34***r* surrounding the toner outlet W is gradually narrowed toward the tips **34***r***1** in the longitudinal direction (open and close direction of the shutter **34***d*). Therefore, when the shutter **34***d* closes the toner outlet W, sliding contact between the shutter seal **36** attached to the shutter **34***d* and the rim **34***r* of the toner outlet W is started at the tip **34***r***1** having a smaller area. Then, the contact area between the shutter seal **36** and the side rims **34***r***10** of the rim **34***r* is gradually increased as the width of the enclosure of the rim **34***r* increases. With this configuration, although the shutter seal **36** contacts the rim **34***r*, peeling the shutter seal **36** from the shutter **34***d* or damage to the shutter seal **36** can be prevented. Conversely, when the shutter **34***d* opens the toner outlet W, the contact area between the shutter seal **36** and the side rims **34***r***10** is gradually decreased, and therefore, the damage to the shutter seal **36** caused by the contact with the rim **34***r* can be reduced.

In addition, referring to FIG. **47**, the surroundings of the toner supply opening **73***w* of the cap holder **73** (see FIG. **42**) is sealed with a seal member **76** formed of elastic material (e.g., foam resin). Therefore, toner scattering in the vicinity of the toner supply opening **73***w* communicating with the toner outlet W of the toner container **32**Y can be prevented. Therefore, similarly, in installation of the cap member **34**Y into the cap holder **73** in the longitudinal direction, when the rim **34***r* of the cap **34**Y contacts the seal member **76** on the vicinity of the toner supply opening **73***w*, initially, sliding contact between the rim **34***r* and the seal member **76** is started at the tip **34***r***1** having a smaller area. Then, the contact area between the seal member **76** and the side rims **34***r***10** of the rim **34***r* is gradually increased as the width of the enclosure of the rim **34***r* increases.

Accordingly, the peeling the seal member **76** from the toner supply opening **73***w* and damage to the seal member **76** can be alleviated. Conversely, in releasing the cap **34**Y from the cap holder **73** in the longitudinal direction, the contact area (sliding area) between the side rim **34***r***10** of the rim **34***r* and the seal member **76** on the toner supply opening **73***w* is gradually decreased, and therefore, the damage to the seal member **76**

surrounding the toner supply opening **73***w* caused by the contact with the rim **34***r* can be reduced.

It is to be noted that in FIG. **47**, the cap **34**Y and the seal member **76** are illustrated upside down so as to clearly show the relative positions of the seal member **76** surrounding the toner supply opening **73***w* and the toner outlet W.

Undergoing these processes, the toner contained in (retained in) the toner container **32**Y can be reliably prevented from being scattered outside as the toner container **32**Y is installed in or released from the image forming apparatus **100**.

It is to be noted that, although not clearly shown in the drawings, in the present embodiment, the projecting amount of the rim **34***r* shown in FIG. **20** of the cap **34**Y gradually decreases in the longitudinal direction (vertical direction in FIG. **45**) with increases in the distance from the center position of the toner outlet W, that is, the height of the rim **34***r* of the cap **34**Y decreases toward the tips **34***r***1** on both sides in the longitudinal direction.

In this configuration, when the shutter seal **36** attached to the shutter **34***d* slides on the rim **34***r* in synchronization with the installation of the toner container **32**Y in the longitudinal direction, peeling the shutter seal **36** from the shutter **34***d* can be prevented, and the shutter seal **36** is less likely to be damaged. Similarly, when the rim **34***r* slides on seal member **76** (see FIG. **42**) surrounding the toner supply opening **73***w* in synchronization with the installation of the toner container **32**Y in the longitudinal direction, peeling the seal member **76** from the toner supply opening **73***w* can be prevented, the seal member **76** is less likely to be damaged.

It is to be noted that the shape of the rim **34***r* and the toner outlet W is not limited the above-described configuration. FIGS. **48**A and **48**B illustrate variations of the shape of the rim **34***r* and the toner outlet W. For example, as shown in FIG. **48**A, a projection amount of a tip portions in the longitudinal direction of a rim **34***r-a* gradually decreases with increases in the distance from the center position of the toner outlet W. More specifically, tapered tips **34***r***3** sloped in the vertical direction are provided outside the tips **34***r***1** on both sides of the rim **34***r-a*.

In addition, as shown in FIG. **48**B, a toner outlet W-b formed on the bottom surface of the cap **34**Y is rectangular although a rim **34***r-b* that surround the rectangular toner outlet W-b is hexagonal. In this configuration, in order to form apexes of the rim **34***r-b*, the rim **34***r-b* includes a pair of triangular portions **34***r***4** positioned both end portions of the rim **34***r-b* in the longitudinal direction, and the triangle rim **34***r***4** is tapered, that is, sloped in the vertical direction.

Similarly to the configuration shown in FIG. **47**, in a variation shown in FIGS. **48**A and **48**B, when the shutter **34***d* closes the toner outlet W, sliding contact between the rim **34***r* surrounding the toner outlet W and the shutter seal **36** attached to the shutter **34***d* or the seal member **76** attached to the toner supply opening **73***w* is started at the tip **34***r***1** having smaller area. Then, the contact area between the side rims **34***r***10** of the rim **34***r* and the seal member **76** or the shutter seal **36** is gradually increased as the width of the enclosure of rim **34***r* increases, and vice versa. With this configuration, because the seal member **76** or the shutter seal **36** can smoothly slide on the rim **34***r*, peeling the shutter seal **36** from the shutter **34***d* or peeling the seal member **76** from the toner supply opening **73***w* and the damage to the shutter seal **36** or the seal member **76** can be prevented

Herein, the respective color toners contained in the toner container **32**Y, **32**M, **32**C, and **32**K according to the embodiments of the present invention have a volume average particle diameter of 3 μm to 8 μm. Additionally, the ratio of Dv/Dn is 1.00 to 1.40 when Dv represents a volume average particle diameter and Dn represents a number average particle diameter.

Accordingly, the high quality image can be kept, and suitable developing ability can be kept even when the toner is agitated in the development device **5** for a relatively long time. In addition, the above-described toner particles can be effectively and reliably transported without clogging the toner supply path such as the toner conveying tube **63**Y. It is to be noted that volume average particle diameter Dv, and number average particle diameter Dn of the toner particles can be measured by COULTER Counter TA-II (COULTER ELECTRONIC COMPANY) and COULTER Multisizer II (COULTER ELECTRONIC COMPANY).

In addition, as for the toner contained in the toner container **32**Y, **32**M, **32**C, and **32**K, substantially spherical toner that desirably has a first shape factor SF**1** and a second shape factor SF**2** both within a range of 100 to 180 is used.

Therefore, higher transfer effectiveness can be kept while preventing degradation of cleaning performance. Further, the toner can be supplied effectively and reliably without clogging the toner supply path, such as the toner conveying tube **63**.

Herein, referring to FIG. **7**, the first shape factor "SF-**1**" is a parameter representing the roundness of a particle and can be calculated by the following formula:

$$SF1=\{M^2/S\}\times(100\pi/4) \quad \text{(Formula 1)}$$

wherein M represents the maximum particle diameter of a spherical shaped figure obtained by projecting a toner particle on a two dimensional plane, and "S" represents the projected area of elliptical-shaped figure.

The toner particle is a perfect sphere when the first shape factor SF**1** is 100. The larger the SF**1** becomes, the more the toner particle becomes amorphous.

In addition, the second shape factor "SF-**2**" is a value representing irregularity (i.e., a ratio of convex and concave portions) of the shape of the toner particle. The shape factor "SF-**2**" of a particle is calculated by the following Formula 2:

$$SF2=\{N^2/S\}\times(100\pi/4) \quad \text{(Formula 2)}$$

wherein N is a peripheral length of a toner particle projected on a two-dimensional surface and d "S" represents the projected area of elliptical-shaped figure.

The toner particle is flat when the first shape factor SF**1** is 100. The larger the first shape factor SF**1** becomes, the more the toner particle has irregularities.

The first shape factor SF**1** and second shape factor SF**2** can be measured by taking a photograph using a scanning electron microscope, S-800 (Hitachi, Ltd.) and analyzing the photograph using an image analyzer, LUSEX3 (NIRECO CORPORATION).

Next, turning now to FIGS. **32** through **46**, structures and operations of the bottle holder **72** and the cap holder **73** in the toner container frame **70** are described below.

As described with reference to FIG. **4**, the toner container frame **70** includes the bottle holder **72**, the cap holder **73**, and the insertion portion **71**. The user installs the toner container **32**Y into the toner container frame **70** from the insertion portion **71** while holding the handle part **33***d* with the longitudinal side of the toner container **32**Y in the horizontal direction and with the cap **34**Y forming the front end of the toner container **32**Y. The toner container **32**Y inserted through the insertion opening **710** is pressed into the cap holder **73** while sliding on a bottle receiving face **72***a*Y (see also FIGS. **34** and **35**).

Herein, with reference to FIGS. **32** and **33**, bottle receiving faces **72***a*Y, **72***a*M, and **72***a*C, and **72***a*K (hereinafter also collectively "bottle receiving faces **72***a*") for respective colors are formed on the bottle holder **72**, and the toner containers **32**Y **32**M, **32**C, and **32**K are inserted into the corresponding portions of the bottle holder **72** in a direction indicated by an arrow shown in FIGS. **32** and **33**. Thus, the bottle receiving face **72***a* functions as a sliding face on which the toner container **32** slides when the toner container **32** is installed into or released from the toner container frame **70** and also functions as a holder to hold the rotating container body **33**Y after the toner container **32**Y is fully set.

Further, in FIG. **37**, the bottle holders **730**Y, **730**M, **730**C, and **730**K for respective color toners are formed in the cap holder **73**, and, when the toner containers **32**Y, **32**M, **32**C, and **32**K are inserted into the toner container frame **70** in the direction indicated by the arrow shown in FIGS. **32** and **33**, the caps **34**Y, **34**M, **34**C, and **34**K are held in position not to rotate by the respective cap holders **73**Y, **73**M, **73**C, and **73**K.

Referring to FIGS. **32** through **36**, the bottle holder **72** of the toner container frame **70** further includes, for each color, a torsion coil spring **72***f* in addition to the bottle receiving face **72***a*, the stopper-release pressing member **72***b*, a pressing member **72***c*, the pressure receiving member **72***d*, and the compression spring **72***e*.

In FIG. **33**, the pressing member **72***c* is provided in the right side sidewall of the bottle holder **71***a* and disposed on the downstream side in the direction of insertion of the toner container **32**Y. As shown in FIGS. **34** and **36**, a tip of the pressing member **72***c* is mountain-shaped or trapeziform, and the bottom portion of the pressing member **72***c* is connected to the one side of the compression spring **72***e*. The pressing member **72***c* is biased leftward in FIG. **33** by the compression spring **72***e*.

By contrast, in FIG. **33**, the pressure receiving member **72***d* is provided on the left side sidewall of the bottle receiving face **72***a* facing the pressing member **72***c* and is positioned on the downstream side in the direction of insertion of the toner container **32**Y. As shown in FIG. **35**, the pressure receiving member **72***d* is curved V-shaped whose valley portion faces a right lower side in FIG. **33**, and the torsion coil spring **72***f* is connected to the valley portion. The pressure receiving member **72***d* can pivot around a shaft of the coil portion of the torsion coil spring **72***f*.

Then, the position of the cap **34**Y is determined by the above-configured the pressing member **72***c* and the pressure receiving member **72***d* just before the cap **34**Y is inserted into the cap holder **73** in installation of the toner container **32**Y into the toner container frame **70**. More specifically, the cap **34**Y is pressed leftward in FIG. **33** by the pressing member **72***c* while the pressing rail **34***n***2** (see FIG. **15**) of the cap **34**Y engages the pressing member **72***c*. Then, while the pressure receiving face **34***n***3** (see FIG. **14**) slides on the pressure receiving member **72***d*, the pressure receiving member **72***d* receives the pressing force thus exerted on the cap **34**Y by the pressing member **72***c*. Thus, the position of the cap **34**Y in the bottle holder **72** can be determined on the right side and the left side in FIG. **33**.

With reference to FIGS. **37** through **41**, the cap holder **73** of the toner container frame **70** includes the main-reference pin **73***a*, the sub-reference pin **73***b*, the engaged portion **73***m*, the pair of lateral grooves **73***c*, the pair of shutter closing members **73***d* (shutter retainer), the toner supply opening **73***w* surrounded by the wall **73***w***1**, an escape portion **73***k*, the antenna **73***e* dedicated for the RFID chip **35**, and the driving gear **81**.

As described-above using FIG. **14**, the main-reference pin **73***a* and the sub-reference pin **73***b* are respectively fitted into the primary positioning hole **34***a* and the secondary positioning hole **34***b*. Thus, the position of the cap **34**Y in the cap holder **73** is determined.

Herein, with reference to FIG. **41**, the main-reference pin **73***a* has a length longer than that of the sub-reference pin **73***b* in the longitudinal direction. The positions of bases (reference faces) of the pins **73***a* and **73***b* are on the same plane. In addition, the main reference pin **73***a* is tapered whose diameter decreases toward a tip thereof. Thus, the cap **34**Y can be smoothly inserted into the cap holder **73** in the longitudinal direction in the installation process of the toner container **32**Y into the container frame **70**.

In addition, the engaged portions **73***m* engage the first engaging member **34***e* and the second engaging member **34***f*, serving as the first restriction members, formed in the cap **34**Y of the toner container **32**Y. Therefore, the cap **34**Y is inserted into or released from the cap holder **73** while the horizontal position of the cap **34**Y is restricted by the first engaging member **34***e* and the second engaging members **34***f* respectively engaged with the engaged portions **73***m*. Then, in the state in which the cap **34**Y is set in to the cap holder **73**, the horizontal position of the cap **34**Y is restricted.

In addition, the lateral grooves **73***c* engage the lateral protrusions **34***c* (second restriction member) formed in the cap **34**Y of the toner container **32**Y. With this configuration, the cap **34**Y is installed into the cap holder **73** while the position of the cap **34**Y in the rotation direction is restricted by the two lateral protrusions **34***c* (second restriction members) engaged with the lateral grooves **71***c* (groove) of the cap holder **73** shown in FIG. **38**.

Next, operation of the shutter closing member **73***d* in conjunction with the opening and closing operation of the shutter **34***d* is described in further detail below with reference to FIGS. **43** through **45**.

Referring to FIG. **43**, in the opening operation of the shutter **34***d*, initially, as the cap **34**Y of the toner container **32**Y is installed into the cap holder **73** in a direction indicated by an arrow in FIG. **43**, the first arms **73***d***1** contact the outer vertical surface **34***s* of the projection members **34***m*, and the second arm **73***d***2** contact the handle parts **34***d***11**.

Referring to FIG. **44**, when the toner container **32**Y is further inserted into the toner container frame **70** from the state shown in FIG. **43**, because the outer vertical faces **34***s* of the cap **34**Y press the long arms **73***d***1** of the shutter closing members **73***d*, the shutter closing members **73***d* (shutter retainer) are rotated around the rotation shaft **73***d***3** as indicated by arrow O shown in FIG. **43**. Subsequently, the first arms **73***d***1** hold the outer vertical faces **34***s* of the projection portions **34***m*, and the second arms **73***d***2** hold the side walls **34***d***11***c* of the handle parts **34***d***11** in the main shutter portion **34***d***1** of the shutter **34***d* while engaging the engagement wall **34***d***11***a* of the handle part **34***d***11** of the shutter **34***d*.

Subsequently, when the toner container **32**Y is further inserted into the toner container frame **70** from the state shown in FIG. **44**, the shutter **34***d* contacts the wall **73***w***1** surrounding the toner supply opening **73***w* in the cap holder **73** (see FIG. **38**) and is sandwiched between the wall **73***w***1** and the second arm **73***d***2**. In this state, the shutter **34***d* cannot proceed any further in the direction of insertion. That is, the absolute movement of the shutter **34***d* is stopped and the shutter **34***d* does not move in the cap holder **73**. However, because the cap **34**Y of the toner container **32**Y can further move forward in the direction of insertion with the shutter **34***d* fixed in position in the cap holder **73**, the shutter **34***d* moves relative to the cap **34**Y of the toner container **32**Y.

More specifically, in the state shown in FIG. **45**, as the shutter support portion **34**Y**1**B of the cap **34**Y further moves in the cap holder **73** in the direction of insertion while the shutter **34***d* is stopped in the cap holder **73**, the shutter **34***d* can open the toner outlet W by moving relative from the cap **34**Y side to the container body **33**Y side. At this time, in FIG. **45**, the shutter **34***d* opens the toner outlet W while the first arms **73***d***1** hold both sides of the outer vertical faces **34***s* of the shutter support section **34**Y**1**B of the cap **34**Y, and the second arms **73***d***2** hold the handle part **34***d***11** of the shutter **34***d*. Therefore, the state of the shutter **34***d* and the cap **34**Y in the cap holder **73** is determined, and the shutter **34***d* can be smoothly opened.

On the other hand, in detachment of the cap **34**Y of the toner **32**Y from the cap holder **73** of the toner container frame **70**, the above-described operation is performed in the reverse sequence (vise versa). That is, when the toner container **32**Y is pulled out from the toner container from **73**, the shutter closing members **73***d* are moved from the state shown in FIG. **45** to the state shown in FIG. **43**, via the state shown in FIG. **44** as the shutter **34***d* closes the toner outlet W.

As described above, in the present embodiment, because the outer vertical faces **34***s* is longer in the direction of insertion (upward in FIG. **44**, the timing at which the shutter closing member **73***d* releases the outer vertical faces **34***s* held by the first arms **73***d***1** can be delayed from when the shutter closing members **73***d* completely closes the shutter **34***d*. More specially, because the outer vertical face **34***s* of the projection portion **34***m* is lengthened to project upward in FIG. **44**, when the shutter **34***d* closes from the state shown in FIG. **45** to the state shown in FIG. **44**, with the first arms **73***d***1** holding the outer vertical faces **34***s* of the projection portions **34***m* and the second arms **73***d***2** holding the handle parts **34***d***11** of the shutter **34***d*, the shutter **34***d* can fully closed while preventing the shutter closing member **73***d* from rotating in the direction indicated by arrow P in FIG. **44** (to a state shown in FIG. **43**).

Namely, if the outer vertical faces **34***s* are not extended to project forward (upward in FIG. **44**), the first arms **73***d***1** release the holding outer vertical face **34***s* earlier than in the configuration shown in FIGS. **43** through **45**, and accordingly the shutter closing members **73***d* are relatively early rotated in the arrow P direction in FIG. **43** although the shutter **34***d* has not yet fully closed the toner outlet W.

By contrast, in the present embodiment, because the cap **34**Y includes the projection portions the toner container **32**Y is not released from the image forming apparatus before the shutter **34***d* fully closes the toner outlet W.

It is to be noted that, with reference to FIGS. **38** and **39**, because the projection portion **34***m* projects forward from the reference wall face **34***a*, in order not to hit an inner front wall of the cap holder **73**, escape portions **73** constituted as holes or concave portions are formed in the inner surface of the cap holder **73**, in portions facing the projection portion **34***m*, and therefore, the projection portion **34***m* is fitted into the escape portion **73***k*.

Next, with reference to FIGS. **35** and **46**A through **46**D, the states of the cap **34**Y in the cap holder **73** and bottle holder **72** in insertion of the toner container **32**Y are described below.

Initially, referring to FIG. **35**, in the insertion of the toner container **32**Y into the bottle holder **72**, the cap **34**Y slides on the bottle receiving face **72***a* and is held by the pressing member **72***c* and pressure-receiving member **72***d*, jolting of the cap **34**Y immediately before the cap **34**Y is inserted into the cap holder **73** is inhibited.

Subsequently, the first engaging member **34***e* and the second engaging members **34***f* engage the engaged portion **73***m*, and the lateral protrusions **34***c* are fitted into the lateral grooves **73***c*, thus fixing the position of the cap **34**Y in the lateral direction and vertical direction in the cap holder **73**. At this time, the state of the cap **34**Y is shifted from the position shown in FIG. **46**A to the position shown in FIG. **46**B.

Subsequently, as shown in FIG. **46**C, the main-reference pin **73***a* of the cap holder **73** is fitted into the primary positioning hole **34***a* of the cap **34**Y, and then the sub-reference pin **73***b* is fitted into the secondary positioning hole **34***b* of the cap **34**Y. The step-by step positioning of the cap **34**Y in the cap holder **73** is completed.

In addition, while the positioning is performed (before engagement between the sub-reference pin **73***b* and the secondary positioning hole **34***b* is completed), the stopper-release pressing members **72***b* release the contact between the stopper **34***d***22** of the shutter **34***d* and the contact face **34***n***5** of the shutter container **34***n* in the cap **34**Y, and then, the shutter closing members **73***d* (shutter retainer) determine the position of the shutter **34***d* and the cap **34**Y in the cap holder **73** (see FIG. **46**C). Thus, the shutter **34***d* is opened by the shutter closing members **73***d*.

Additionally, before the engagement between the secondary positioning hole **34***b* and the sub-reference pin **73***b* is completed, the rim (wall) **72***w***1** surrounding the toner outlet W of the cap **34**Y slides on the seal member **76** surrounding the toner supply opening **73***w* in the cap holder **73**.

Then, the opening toner outlet W of the cap **34**Y communicates with the toner supply opening **73***w*, and consequently, the setting of the cap **34**Y of the toner container **23**Y in the cap holder **73** in the toner container holder **70** is completed (see FIG. **46**D). At this time, the gear **33***c* of the container body **33**Y engages the driving gear **81** in the image forming apparatus **100**, and the RFID chip **35** of the cap **34**Y is set to a position suitable for communication with the antenna **73***e* in the image forming apparatus **100**.

As described above, in the present embodiment, in the installation of the toner container **32**Y into the toner container frame **70**, because the position of shutter **34***d* of the cap **34**Y is determined in the cap holder **73** by the shutter closing member **73***d*, opening the shutter **34***d* in a tilted state can be prevented. In addition, in the installation of the toner container **32**Y, after the main-reference pin **73***a* in the cap holder **73** is fitted into the primary positioning hole **34***a* of the cap **34**Y, that is, main positioning is finished, the position of the shutter **34***d* in the cap holder **73** is determined by the shutter closing member **73***d* (shutter retainer). Then, the sub-reference pin **73***b* of the cap holder **73** is fitted into the secondary positioning hole **34***b* of the cap **34**Y, that is, sub-positioning is finished, and thus, step by step positioning is completed. Therefore, the positions of the shutter **34***d* and cap **34**Y can be corrected before step-by step positioning is completed.

In addition, before the position of the cap **34**Y is determined by fitting the main-reference pin **73***a* into the primary positioning hole **34***a*, the lateral position as well as vertical position of the cap **34**Y is restricted by fitting the lateral protrusions **34***c* of the cap **34**Y into the lateral grooves **73***c* in the cap holder **73** and the like, and therefore, the cap **34**Y can be smoothly inserted into the cap holder **73**.

Further, after the shutter closing members **73***d* determine the position of the shutter **34***d* and the cap **34**Y in the cap holder **73**, the seal member **76** surrounding the toner supply opening **73***w* slides on the rim **34***r* surrounding the toner outlet W in the cap **34**Y. Subsequently, the secondary positioning hole **34***b* of the cap **34**Y engages the sub-reference pin **73***b*, thus step-by-step positioning is completed. Therefore, the position of the shutter **34***d* of the cap **34**Y can be corrected without receiving the sliding resistance caused between the seal member **76** and the toner outlet W. In addition, in the

present embodiment, because the shutter closing members **73***d* are provided close to not the main-reference pin **73***a* but the sub-reference pin **73***b*, the position of the shutter **34***d* and the cap **34**Y in the cap holder **73** can be easily corrected.

Conversely, in the removal of the toner container **32**Y from the toner container frame **70**, after the engagement between the secondary positioning hole **34***b* of the cap **34**Y and the sub-reference pin **73***b* of the cap holder **73** is released, the engagement state between the primary positioning hole **34***a* of the cap **34**Y and the main-reference pin **73***a* is kept until the closing process of the shutter **34***d* is completed. Therefore, closing the shutter **34***d* in the cap **34**Y in a tilted state can be prevented.

It is to be noted that, in FIG. **42**, because the seal member **76** is provided around the toner supply opening **73***w* in the cap holder **73** to prevent the leakage of the toner from a gap between the opening toner outlet W in the cap **34**Y and the toner supply opening **73***w* in the cap holder **73** as described above, when the cap **34**Y is in the cap holder **73**, a reaction force generated by the elastic deformation of the seal member **76**, which is an upward force in FIG. **28**A, is exerted on the cap **34**Y. However, as shown in FIG. **27**, in the cap **34**Y according to the present embodiment, the primary positioning hole **34***a* that engages the main-reference pin **73** is formed just above the toner outlet W, at the position on which the reaction force from the seal member **76** is exerted. Therefore, floating and tilt of the cap **34**Y caused by the reaction force can be prevented.

Further, referring to FIG. **28**A, in the cap **34**Y according to the present embodiment, the primary positioning hole **34***a* that engages the main-reference pin **73***a* is at a farthest position (ceiling) from the toner outlet W connected to the toner supply opening **73***w*, above the toner outlet W. Therefore, if backlash is present in the engagement between the main-reference pin **73***a* and the primary positioning hole **34***a*, thereby causing the cap **34**Y to tilt, the tilt of the cap **34**Y is less likely to cause the positional deviation of the toner outlet W relative to the toner supply opening **73***w* in the cap **34**Y according to the present embodiment.

As described above, in the image forming apparatus **100** according to the present embodiment, besides opening and closing the main body cover **110**, users can complete insertion and removal of the toner container **32**Y from the image forming apparatus **100** with a single action of moving the toner container **32**Y in the longitudinal direction while handling the handle part **33***d* because the shutter **34***d* opens and closes the toner outlet W in synchronization with the movement of the toner container **32**Y.

In addition, in the toner container **32**Y according to the present embodiment, because the toner outlet W opens downward and has a relatively large opening area, the toner can be discharged from the toner outlet W directly under its own weight.

Further, the toner container **32**Y is installed in the toner container frame **70** in the image forming apparatus **100** not from above but from a front side of the toner container frame **70** in the image forming apparatus **100**. Therefore, design flexibility in layout above the toner container frame **70** can be enhanced. For example, even when a scanner (document reader) is positioned just above the toner supply device **60**, the workability and operability of installation and removal of the toner container **32**Y in/from the toner container frame **70** in the image forming apparatus **100** is not degraded.

In addition, because the toner container **32**Y is installed in the image forming apparatus **100** with its long side horizontal, toner capacity of the toner container **32**Y can be increased without sacrificing the design flexibility in vertical layout of the entire the image forming apparatus **100**, and frequency of replacement of the toner container **32**Y can be reduced.

As described above, the toner container **32**Y according to the present embodiment includes the shutter **34***d* that moves in the longitudinal direction to open and close the toner outlet W formed in the bottom surface of the cap **34**Y, the primary positioning hole **34***a* and the secondary positioning hole **34***b* disposed at suitable positions, respectively serving as the main-positioning reference and the sub-positioning reference, and the first restriction member including the first engaging member **34***e* and the second engaging members **34***f* both disposed close to the primary positioning hole **34***a*. Thereby, the setting space for the toner container **32**Y in the image forming apparatus **100** can be secured and installation and removal of the toner container in/from the toner container frame **70** in the image forming apparatus **100** can be facilitated. Therefore, when the toner is discharged from the toner outlet under its own weight, the position of the cap **34**Y is reliably determined in the image forming apparatus **100** at a suitable position without any adverse effect to discharge of the toner.

Second Embodiment

A second embodiment is described below with reference to FIGS. **49** through **51**.

FIG. **49** is a schematic perspective diagram illustrating vicinity of a cap **34**Y-α of a toner container **32**Y-α according to the second embodiment and corresponds to FIG. **15** of the first embodiment. FIG. **50** is a front vied illustrating the cap **34**Y-α and corresponds to FIG. **8** that illustrates the cap **34**Y according to the first embodiment FIG. **51** is a schematic perspective diagram illustrating a cap-surrounding portion **731**Y-α in the cap holder **73**-α in which the cap **34**Y-α is inserted.

The configuration of lateral protrusions **34***c*-α in this embodiment is different from the lateral protrusions **34***c* in the first embodiment.

With reference to FIGS. **49** and **50**, similarly to the toner container **32**Y in the first embodiment, the toner container **32**Y-α also includes the container body **33**Y and the cap **34**Y-α in the present embodiment. It is to be noted that, for ease of illustration and description, the primary positioning hole **34***a* (main-positioning reference) and the secondary positioning hole **34***b* (sub-positioning reference) are omitted in FIGS. **49** and **50**, and components of the toner container **32**Y-α similar to those of the toner container **32**Y in the first embodiment are given identical numerals and the description thereof is omitted below.

With reference to FIG. **51**, similarly to the cap holder **73** in the first embodiment, a cap holder **73**Y-α includes a pair of lateral grooves **73**-α and engaged portions **73***m*-α. Each of cap-surrounding portions **731**Y-α, **731**M-α, **731**C-α, and **731**K-α in the cap holder **73**-α is rectangular parallelepiped including a cylindrical hollow so as to surround the respective first cap bodies **34**Y**1**-α, **34**M-α, **34**C-α, and **34**K-α. It is to be noted that, in FIG. **51**, although the cap holder **73**Y-α is simplified with the main-reference pin **73***a* and the sub-reference pin **73***b* omitted for simplicity, the main-reference pin **73***a* and the sub-reference pin **73***b* are provided extreme upstream in the inner wall of the cap holder **73** Y-α (backside in FIG. **51**).

In addition, in the cap **34**Y-α according to the second embodiment, the first engaging member **34***e* and the second engaging members **34***f* engage corresponding engaged portions **73***m* (projecting portions) in the cap holder **73** (see FIGS. **49** and **50**). Therefore, the cap **34**Y-α is inserted into or

released from the cap holder **73** while the horizontal position of the cap **34**Y-α is restricted by the first engaging member **34***e* and the second engaging members **34***f* respectively engaged with the engaged portions **73***m*. Then, in the state in which the cap **34**Y-α is set in to the cap holder **73**, the horizontal position of the cap **34**Y-α is restricted.

With this configuration, the cap **34**Y-α is installed into the cap holder **73**-α while the position of the cap **34**Y-α in the rotation direction is restricted by the two lateral protrusions **34***c*-α (second restriction members) shown in FIG. **49** engaged with lateral grooves **73***c*-α (groove) of the cap holder **73**-α shown in FIG. **51**. Then, in the state in which the cap **34**Y is set in the cap holder **73**-α, the position of the cap **34**Y-α in the rotation direction is restricted by the engagement between the lateral protrusions **34**Y-α and the lateral grooves **71***c*-α.

The lateral protrusions **34***c*-α (second restriction member) protruding from lateral sides of the cap **34**Y-α horizontally are arranged symmetrically on a virtual horizontal line passing through a center position of the line, at positions away the center position. Each lateral protrusions **34***c*-α extends in the direction of insertion. Therefore, the cap **34**Y-α can be inserted into the cap holder **73**-α in balanced manner, guided by the lateral groove **73***c*-α of the cap holder **73**-α.

In addition, with reference to FIGS. **49** and **50**, the pair of lateral protrusions **34***c*-α is provided in a small (small outer) diameter portion of the cap **34**Y-α in the front side of the direction of insertion, that is, the lateral protrusion **34***c*-α is formed on the first cap body **34**Y**1**-α shown in FIG. **24**. Moreover, as shown in FIG. **50**, the lateral protrusions **34***c*-α are formed so as not to project from the outer diameter of the second cap body **34**Y**2** when viewed in a cross sectional view perpendicular to the direction of insertion, that is, a direction orthogonal to the surface of paper on which FIG. **50** is drawn. Accordingly, the lateral protrusions **34***c*-α can be formed by using the space effectively without increasing the size of the cap **34**Y-α, that is, the outer diameter of the cap **34**Y-α.

As described above, similarly to the toner container **32**Y-α in the first embodiment, the toner container **32**Y-α further includes the shutter **34***d* that moves in the longitudinal direction to open and close the toner outlet W formed in the bottom surface of the cap **34**Y-α, the primary positioning hole **34***a* and the secondary positioning hole **34***b* disposed at suitable positions, respectively serving as the main-positioning reference, and the secondary positioning hole **34***b* serving as the sub-positioning reference, and the first restriction member including the first engaging member **34***e* and the second engaging members **34***f* both disposed close to the primary positioning hole **34***a*. Thereby, the setting space for the toner container **32**Y-α in the image forming apparatus **100** can be secured and the installation and removal of the toner container in/from the toner container frame **70** in the image forming apparatus **100** can be facilitated. Therefore, when the toner is discharged from the toner outlet W under its own weight, the position of the cap **34**Y-α is reliably determined in the image forming apparatus **100** at a suitable position without any adverse effect to discharge of the toner.

Third Embodiment

A third embodiment is described below with reference to FIGS. **52** and **53**.

FIG. **52** is a schematic perspective diagram illustrating vicinity of a cap **34**Y-β of the toner container **32**Y-β according to the third embodiment and corresponds to FIG. **49** of the second embodiment. FIG. **53** is a schematic perspective diagram illustrating a cap-surrounding portion **731**Y-β in the cap holder **73**-β in which the cap **34**Y-β is inserted, and corresponds to the cap-surrounding portion **731**Y-α in the cap holder **73**-β according to the second embodiment shown in FIG. **51**.

The configuration of lateral protrusions **34***c*-β in this embodiment is different from the lateral protrusions **34***c*-α in the second embodiment.

With reference to FIG. **53**, similarly to the toner container **32**Y in the first embodiment, the toner container **32**Y-β also includes the container body **33**Y-β and a cap **34**Y-β in the present embodiment. It is to be noted that for ease of illustration and description, the primary positioning hole **34***a* (main reference) and the secondary positioning hole **34***b* (sub reference) are omitted in FIG. **52**, and components of the toner container **32**Y-β similar to those of the toner container **32**Y in the first embodiment are given identical numerals and the description thereof is omitted below.

With reference to FIG. **53**, similarly to the toner container **32**Y in the first embodiment, a cap holder **73**Y-β includes a pair of lateral grooves **73**-β and engaged portions **73***m*-β. Each of cap-surrounding portion **731**Y-β, **731**M-β, **731**C-β, and **731**K-β in the cap holder **73**-β is rectangular parallelepiped including a cylindrical hollow in surrounding portion of the first cap bodies **34**Y**1**-β, **34**M**1**-β, **34**C**1**-β, and **34**K**1**-β. It is to be noted that, in FIG. **53**, although the cap holder **73***d* is simplified with the figure of the main-reference pin **73***a* and the sub-reference pin **73***b* omitted for simplicity, the main-reference pin **73***a* and the sub-reference pin **73***b* are provided extreme upstream in the inner wall of the cap holder **73**-β (backside in FIG. **53**).

In addition, in the cap **34**Y-β according to the third embodiment, the first engaging member **34***e* and the second engaging members **34***f* shown in FIG. **52** engage corresponding engaged portions **73***m* (projecting portions) in the cap holder **73**-β (see FIG. **53**). Therefore, the cap **34**Y-β is inserted into or released from the cap holder **73**-β while the horizontal position of the cap **34**Y-β is restricted by the first engaging member **34***e* and the second engaging members **34***f* respectively engaged with the engaged portions **73***m*. Then, in the state in which the cap **34**Y-β is set in to the cap holder **73**-β, the horizontal position of the cap **34**Y-β is restricted.

With this configuration, the cap **34**Y-β is installed into the cap holder **73**-β while the position of the cap **34**Y-β in the rotation direction is restricted by the two lateral protrusions **34***c*-β (second restriction members) shown in FIG. **52** engaged with lateral grooves **73***c*-β (groove) of the cap holder **73**-β shown in FIG. **53**. Then, in the state in which the cap **34**Y-β is set in the cap holder **73**-β, the position of the cap **34**Y-β in the rotation direction is restricted by the engagement between the lateral protrusions **34**Y-β and the lateral grooves **71***c*-β.

The lateral protrusions **34***c*-β (second restriction member) protruding from lateral sides of the cap **34**Y-β horizontally are arranged above a virtual horizontal plane passing through a center position of the cap **34**Y-β, at positions away the center position. That is, the lateral protrusions **34***c*-β is disposed far from the toner outlet W.

Further, as shown in FIG. **53**, each of the lateral grooves **73***c*-β of the cap holder **73**-β is provided at an upper position facing the lateral protrusions **34***c*-β, compared with the position of the lateral grooves **73***c*-α in the second embodiment shown in FIGS. **49** and **50**. In this configuration, in the cap **73**Y-β, because the distance between the outer ends of the lateral grooves **73***c*-β in the width direction (horizontal direction) can be reduced, the width (horizontal length in the direction perpendicular to the longitudinal direction) of the

cap holder **73**Y-β can be narrowed, that is, the respective cap-surrounding portion **731**Y of the cap holder **73**-β can be made more compact.

In addition, compared with a comparative configuration in which lateral positions **34***c*-β are arranged beneath the virtual horizontal plane (closer to the toner outlet W), in the configuration the lateral protrusions **34***c*-β are positioned above the virtual horizontal plane passing through the center position of the cap **34**Y-β, even when the width (horizontal direction) of the lateral protrusions **34***c*-β are relatively small, floating and the tilt of the toner container **32**Y-β can be prevented by the reaction force caused by the seal member **76** provided between the toner outlet W and the toner supply opening **73***w*.

As described above, similarly to the toner container **32**Y in the first embodiment, the toner container **32**Y-β includes the shutter **34***d* that moves in the longitudinal direction to open and close the toner outlet W formed in the bottom surface of the cap **34**Y-β, the primary positioning hole **34***a* and the secondary positioning hole **34***b* disposed at suitable positions, respectively serving as the main-positioning reference, and the sub-positioning reference, and the first restriction member including the first engaging member **34***e* and the second engaging members **34***f* both disposed close to the primary positioning hole **34***a*. Thereby, the setting space for the toner container **32**Y-β in the image forming apparatus **100** can be secured and the installation and removal of the toner container in/from the toner container frame **70** in the image forming apparatus **100** can be facilitated. Therefore, when the toner is discharged from the toner outlet W under its own weight, the position of the cap **34**Y-β is reliably determined in the image forming apparatus **100** at a suitable position without any adverse effect to discharge of the toner.

Fourth Embodiment

A fourth embodiment is described below with reference to FIGS. **54** through **56**.

FIG. **54** is a schematic cross sectional view illustrating a cap **34**Y-γ of a toner container **32**Y-γ when viewed in the longitudinal direction of a toner container **32**Y-γ and illustrates a cross section of the cap **34**Y-γ perpendicular to the longitudinal direction, at the position of a toner outlet W. FIG. **55** is a cross sectional view illustrating the vicinity of the cap **34**Y-γ of the toner container **32**Y-γ and corresponding to FIG. **28**A that illustrates the vicinity of the cap **34**Y according to the first embodiment. FIG. **56** is a perspective view illustrating a flexible member **34***u* provided close to the toner outlet W of the toner container **32**Y-γ.

This embodiment is different from the first embodiment in that the toner container **32**Y-γ includes the flexible member **34***u* disposed close to the toner outlet W.

With reference to FIG. **54**, similarly to the toner container **32**Y in the first embodiment, the toner container **32**Y includes the container body **33**Y and the cap **34**Y-γ. More specifically, with reference to FIG. **55**, which is an exploded view illustrating the toner container **32**Y-γ, the toner container **32**Y-γ includes cap seal **37**, the shutter **34***d*, a shutter seal **36** serving as a seal member, and the RFID chip **35** serving as the electronic data storage, in addition to the container body **33**Y-γ and the cap **34**Y-γ.

Further, with reference to FIG. **54**, similarly to the toner container **32**Y in the first embodiment, in the toner container **32**Y-γ, the agitator **33***f*-γ that rotates together with the container body **33**Y-γ is fitted in the opening A enclosed by the edge face **33***a* (see FIGS. **10** through **12**). In addition, the agitator **33***f* includes the pair of stick member **33***f***1** that protrudes from the circular engagement edge **33***f***2** to the hollow B in the cap **34**Y

Herein, with reference to FIGS. **54** and **55**, different from other embodiments, the flexible member **34***u* that is constructed of a flexible member such as Mylar (registered trademark) having a thickness ranging from 0.188 mm to 0.500 mm extends from the toner drop route C to the hollow B in the cap **34**Y-γ.

More specifically, as shown in FIG. **56**, the flexible member **34***u* that is a strip having a single bent portion like a boomerang, and is divided by the bent portion into a fixing portion **34***u***1** and a flexible portion **34***u***2**. The fixing portion **34***u***1** that is wider than the flexible portion **34***u***2** functions as an attachment face and is attached to (glued to) an interior wall of the toner dropping route C positioned close to the interior wall of the toner outlet W, that is, positioned close to the interior wall on the downstream side in the rotation direction of the agitation member **33***f*. Further, the fixing portion **34***u***2** is bonded to the interior wall of the toner dropping route C so that the bending portion of the flexible member **34***u* is positioned in the toner dropping route C.

Further, a tip of the flexible portion **34***u***1** of the flexible member **34***u* is a free end and the flexible portion **34***u***1** extends from the toner dropping route C to the hollow B. In addition, the tip of the flexible portion **34***u***1** vibrates by contacting the rotating stick members **33***f***1** of the agitation member **33***f*. Therefore, when the toner dropping route C is clogged with toner close to the toner outlet W), the toner accumulated in the vicinity of the toner outlet W can be separated by the flexible member **34***u*, and accordingly the toner can be further smoothly discharged from the toner outlet W.

It is to be noted that the configuration of the flexible member **34***u* is not limited to the shape according to the present embodiment, and, for example, the flexible member **34***u* can adopt shapes without a bending portion or the shape of the fixing portion can be changed.

Herein, similarly to the toner container **32**Y-α in the first embodiment, the toner container **32**Y-γ further includes the shutter **34***d* that moves in the longitudinal direction to open and close the toner outlet W formed in the bottom surface of the cap **34**Y-γ, the primary positioning hole **34***a* and the secondary positioning hole **34***b* disposed at suitable positions, respectively serving as the main-positioning reference and the sub-positioning reference, at suitable position, and the first restriction member including the first engaging member **34***e* and the second engaging members **34***f* both disposed close to the primary positioning hole **34***a*. Thereby, the setting space for the toner container **32**Y-γ in the image forming apparatus **100** can be secured and the installation and removal of the toner container in/from the toner container frame **70** in the image forming apparatus **100** can be facilitated. Therefore, when the toner is discharged from the toner outlet W under its own weight, the position of the cap **34**Y-γ is reliably determined in the image forming apparatus **100** at a suitable position without any adverse effect to discharge of the toner.

It is to be noted that although including single-component developer consisting essentially of only toner in the above-descried embodiments, the toner container **32**Y, **32**M, **32**C, and **32**K can also contain two component developer including toner and carrier to suitably supply a two-component development device. In this case, the effects described above can be achieved.

In addition, in the above-described embodiments, part or all of each of the image forming units **6**Y, **6**M, **6**C, and **6**K can be housed in a common unit casing and thus be formed as a

process cartridge. In this case, the similar effects as those in the above-described embodiments can be attained.

Fifth Embodiment

FIG. **57** is a cross sectional view illustrating a container body **33** according to a fifth embodiment.

Although the container body **33**Y is rotatable relative to the cap **34**Y to convey the toner contained in the container body **33**Y to the opening A in the above-described embodiments, in the present embodiment neither a container body **33**Y-δ nor a cap **34**Y-δ are rotatable when installed in the toner container holder **70**. Instead, the container body **34**Y-δ includes a conveyance member **46**Y to convey the toner contained in the container body **33**Y-δ to the opening A. For example, a conveyance member is a rotary member to rotate in a predetermined direction and includes a rotary shaft **45**Y and a conveyance coil or multiple conveyance blades.

More specifically, as shown in FIG. **57**, the toner container **32**Y-δ mainly includes the container body **33**Y-δ, a gear **44**Y, and the cap **34**Y-δ (bottle cap). The opening A-δ is formed on the top of the container body **33**Y-δ and the outer surface of the opening A-δ, and the gear **44**Y is rotatably attached around the outer surface of the opening A-δ.

The gear **44**Y engages the driving gear **81** in the image forming apparatus **100** and rotates around the opening A-δ of the container body **33**Y-δ for rotating a coil **46**Y around a rotary shaft **45**Y. Further, the toner contained in the container body **33**Y-δ is discharged from the opening A-δ to space B-δ in the cap **34**Y-δ. The gear **44**Y and the rotary shaft **45**Y together form a single member, and the rotary shaft **45**Y is connected to the spiral shaped coil **46**Y serving as the conveyance member. The one end of the rotary shaft **45**Y is supported by a bearing **34**Y-δ of the cap **34**Y-δ. The coil **46**Y extends from the opening W to the backside portion of the (bottom portion) of the container body **33**Y-δ. With this configuration, as the gear **44**Y rotates around the container body **33**Y-δ, the rotary shaft **45**Y and the coil **46**Y are rotated. Thus, the toner contained in the container body **33**Y-δ is conveyed to the opening A by the conveyance force from the coil **46**Y.

It is to be noted that the gear **44**Y is provided around the outer circumferential surface of the container body **33**Y-δ so that the gear is sandwiched between the inner face of the cap **34**Y-δ and the outer surface of the container body **33**Y-δ.

An elastic member **47**Y is provided between the gear **44**Y and the container body **33**Y-δ, and a seal member **48**Y is formed between the gear **44**Y and the cap **34**Y-δ. In this configuration, the entire toner container **32**Y-δ can be sealed reliably. That is, leakage of the toner from the gaps between the gear **44**Y and the container body **33**Y-δ or the gear **44**Y and the cap **34**Y-δ can be prevented.

Further, the above-described features of the first embodiment to the fourth embodiment can be adapted in the toner container **32**Y-δ according to the present embodiment. Accordingly, the similar effect can be achieved.

In addition, with reference to FIG. **1**, entire toner conveyance route formed of the toner tank **61**Y, the toner conveyance path **63**Y including the toner conveying screw **62**Y, and the toner dropping route **64**Y included in the toner supply device **60**Y is И -shaped when viewed from a direction orthogonal to the surface of paper on which FIG. **1** is drawn. In addition, in FIG. **1**, the toner dropping route **64**Y and the downstream side of the toner conveyance path **63**Y in the toner conveyance direction is provided immediately above the image forming unit **6**Y (process cartridge), that is, the toner dropping route **64**Y and the downstream side of the toner conveyance path **63**Y are provided immediately above an attachment/detachment opening in the image forming apparatus **100** in which the image forming unit **6**Y (process cartridge) is installed.

Further, the toner container **32**, the toner tank **61**, and the upstream side of the toner conveyance path **63** including the toner conveying screw **62** for each color are provided not the image forming section **6** for that color that above the adjacent image forming section **6** for another color (in FIG. **1**, the image forming section **6** on the left). That is, for example, the toner container **32**M, and a toner tank **61**M and the upstream side of a toner conveyance path **63**M for magenta are not positioned immediately above the image forming section **6**M, but above the image forming section **6**Y.

Thus, in a tandem-type image forming apparatus in which multiple image forming units are arranged in parallel, when the image forming units **6** (process cartridge) is attached to or detached from the image forming apparatus **100**, the image forming units **6** and the toner supply devices **60** do not interfere with each other. Therefore, in the image forming apparatus **100**, the length in the vertical direction from the toner containers **32**Y, **32**M, **32**C, and **32**K to the image forming unit **6**Y, **6**M, **6**C, and **6**K can be shortened, and as a result, the fluctuation in the amount of toner supplied to the corresponding development devices **5**Y, **5**M, **5**C, and **5**K can be prevented.

Further, the present invention is not limited to the specifically disclosed embodiments, and variations and modifications may be made without departing from the scope of the present invention. That is, in the embodiments of the present invention, the number of elements, the positions of the corresponding elements, and the shapes of the corresponding elements are not limited to the specifically disclosed embodiments.

Numerous additional modifications and variations are possible in light of the above teachings. It is therefore to be understood that, within the scope of the appended claims, the disclosure of this patent specification may be practiced otherwise than as specifically described herein.

What is claimed is:

1. A toner container to contain toner and removably installable in an image forming apparatus horizontally in a longitudinal direction of the toner container, the toner container comprising:

a toner outlet to discharge toner vertically downward to an outside of the toner container;

a shutter to open and close the toner outlet;

a primary hole formed in an upper surface of the toner container and extending in the longitudinal direction of the toner container from a front surface of the toner container, and perpendicular to the longitudinal direction thereof;

a secondary hole disposed below the primary hole and extending in the longitudinal direction of the toner container not to reach the toner outlet from the front surface of the toner container, and perpendicular to the longitudinal direction thereof toward the toner outlet; and

a restriction member projecting horizontally from lateral sides on an outer circumferential surface of the toner container and extending in the longitudinal direction of the toner container, the restriction member to restrict the toner container with respect to the image forming apparatus.

2. The toner container according to claim **1**, wherein the restriction member includes a tapered front end tip portion.

3. The toner container according to claim **1**, further comprising:

a cylindrical hollow extending in the longitudinal direction of the toner container; and

a cylindrical toner dropping route extending from a lower circumference of the cylindrical hollow toward the toner outlet and having a predetermined cross-sectional area.

4. The toner container according to claim **1**, wherein the secondary hole is elliptical and has a vertical diameter longer than a horizontal diameter thereof.

5. The toner container according to claim **1**, further comprising an electronic data storage to store electronic data disposed on the front surface of the toner container perpendicular to the longitudinal direction thereof, the electronic data storage positioned between the primary hole and the secondary hole.

6. The toner container according to claim **1**, further comprising a rotatable spiral protrusion protruding inward from an inner circumferential face of the toner container.

7. An image forming apparatus comprising the toner container according to claim **1**.

8. A toner container to contain toner, the toner container being removably installable in an image forming apparatus horizontally in a longitudinal direction of the toner container, the toner container comprising:

a toner outlet to discharge toner vertically downward to an outside of the toner container;

a shutter to open and close the toner outlet;

an opening formed in an upper portion of the toner container and extending in the longitudinal direction of the toner container from a front surface of the toner container, to receive a protrusion of the image forming apparatus so that the protrusion is inserted into the opening;

an electronic data storage, provided on the front surface of the toner container and disposed below the opening, to exchange data with an image forming apparatus; and

a plurality of lateral protrusions projecting horizontally from lateral sides on an outer circumferential surface of the toner container and extending in the longitudinal direction of the toner container, the plurality of lateral protrusions to engage a plurality of grooves of the image forming apparatus.

9. The toner container according to claim **8**, wherein each of the plurality of lateral protrusions includes a tapered portion.

10. The toner container of claim **8**, further comprising:

a cylindrical hollow extending in the longitudinal direction of the toner container; and

a cylindrical toner dropping route extending from a lower circumference of the cylindrical hollow toward the toner outlet and having a predetermined cross-sectional area.

11. The toner container of claim **8**, further comprising a secondary opening, wherein the secondary opening is elliptical and has a vertical diameter longer than a horizontal diameter thereof.

12. The toner container of claim **8**, further comprising a rotatable spiral protrusion protruding inward from an inner circumferential face of the toner container.

13. A toner container to contain toner and removably installable in an image forming apparatus horizontally in a longitudinal direction of the toner container, the toner container comprising:

a toner outlet to discharge toner vertically downward to an outside of the toner container;

a shutter to open and close the toner outlet;

an opening formed in an upper portion of the toner container and extending in the longitudinal direction of the toner container from a front surface of the toner container;

an electronic data storage, provided on the front surface of the toner container and disposed below the opening, to exchange data with an image forming apparatus;

a plurality of lateral protrusions projecting horizontally from lateral sides on an outer circumferential surface of the toner container and extending in the longitudinal direction of the toner container, the plurality of lateral protrusions to engage a plurality of grooves of the image forming apparatus; and

a secondary opening, wherein the secondary opening is elliptical and has a vertical diameter longer than a horizontal diameter thereof.

* * * * *